

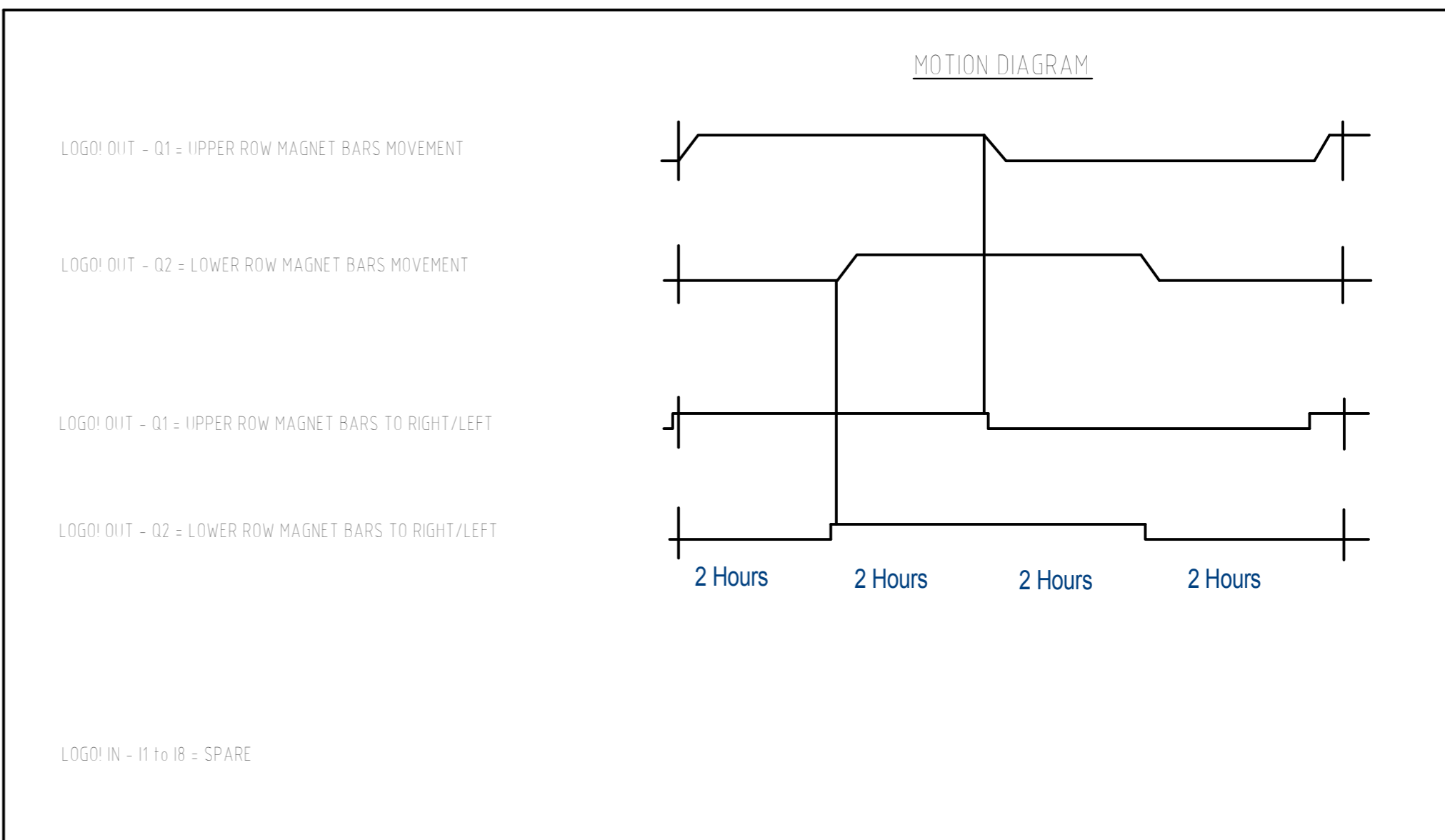
REV	DATE	BY	DESCRIPTION
-	14-5-2013	AvD	NEW REVISION VAULT, NOTHING CHANGED, OLD REV WAS D
A	16-3-2017	AvD	EISE000005 WAS EISD043005

PROCES DEFINITION:

IN PROCES situation:
- Magnet bars ALWAYS remain IN the product channel!!!

Cleaning cycle (iron disposal):

1. LOGO! program creates cleaning action signal every 2 hours, or by start pulse if i6 = high
2. Magnet bar tubes move to LEFT or RIGHT after (Fe) cleaning signal, also taking the separated Fe parts with them to the side channels; (bars move over the magnet bars, that remain in the product channel),
3. After 4 hours tubes move back to other side again, now dropping the iron parts there, or by start pulse if i6 = high
4. This action repeats itself every 4 hours, or by start pulse (parameters 2 and 4 hours can be adapted by editing the time parameter via the LOGO! display "edit parameters" mode



This program is written for SECC continuous cleaning cleanflows. The program generates a time controlled cycle for alternatively cleaning (Fe disposal) of the upper and lower magnet bar row.

Cycle:
2 hours after start: cleaning upper layer of magnet bars,
2 hours later followed by the lower layer of magnet bars,
2 hours later the upper layer, etc.

LOGO! INPUT SIGNALS:
The program expects the cleanflow to be executed without sensors

- i1 = SPARE
- i2 = SPARE
- i3 = SPARE
- i4 = SPARE
- i5 = SPARE
- i6 = SPARE

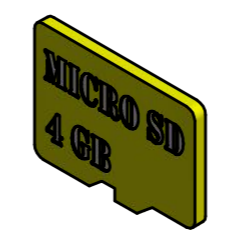
The magnet bar movement is time controlled by software.

LOGO! OUTPUT SIGNALS:
With the help of a time control the program is able to create a sequence movement:

- Q1 high = Magnet bar tubes of UPPER ROW move to drop Fe parts in the RIGHT side chanel
- Q1 low = Magnet bar tubes of UPPER ROW move to drop Fe parts in the LEFT side chanel
- Q2 high = Magnet bar tubes of LOWER ROW move to drop Fe parts in the RIGHT side chanel
- Q2 low = Magnet bar tubes of LOWER ROW move to drop Fe parts in the LEFT side chanel
- Q3 = SPARE
- Q4 = SPARE

LOGO! version 0BA3 (yellow/red eprom):
FILE LOCATION:
F:\groups\Engineering\Logo-programma's\SECC\Programma's V3_1 voor eprom geel en rood - tot 5-04\
FILE:
M24967B SECC 1 layer each 2 hours (standard)-V3_1.lsc

LOGO! version 0BA4 (brown eprom):
FILE LOCATION:
F:\groups\Engineering\Logo-programma's\SECC\Programma's V3_1 voor eprom geel en rood - tot 5-04\
FILE:
M24967B SECC 1 layer each 2 hours (standard)-V4_0.lsc



1	1	EISE000005	MicroSDHC Card Class4	
ITEM	QTY	PART NUMBER	DESCRIPTION	Dimensions
RAW MAT.	1			
Quantity	Material Number	Material Description		Length (mm) Width (mm)
Sheet: A2	Weight (kg): 0	Extra info:		General tolerance: ISO 2768 - mK
Drawn: AvD	Date: 6-6-2000	Goudsmit MAGNETIC SYSTEMS		Drawn according: ISO268; ISO1101; ISO2553
Spare part: False	Quick search: SECC LOGO	© All rights reserved. Reproduction is not permitted without written permission of GOUDSMIT Magnetic Systems BV		Status: Standard
Description: LOGO PROGRAM SECC 2 HOURS		Part number: M24967		Customer reference number: Document number: E0071882 Doc.Rev: A Rev: A