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Parameters and alarms

Vega Transfeed with

Servo

V0100

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1) Machineparameters

1.1) *Overview machine parameters*

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81 Reserved
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83 Reserved
84 Reserved
85 Reserved

1.2) Machine parameters details

01 Loadposition carrier 1 station 1

The loading position of the inner carrier of station 1 (front station). Value is in mm. The higher the value the more the loading position will be to the side of the machine.

02 Loadposition carrier 2 station 1

The loading position of the outer carrier of station 1 (front station). Value is in mm. The higher the value the more the loading position will be to the side of the machine.

03 Loadposition carrier 1 station 2

The loading position of the inner carrier of station 2 (rear station). Value is in mm. The higher the value the more the loading position will be to the side of the machine.

04 Loadposition carrier 2 station 2

The loading position of the outer carrier of station 2 (rear station). Value is in mm. The higher the value the more the loading position will be to the side of the machine.

05 Centerposition 1 lane feeding

The middleposition in case of 1-lane feeding in mm.

06 Centerposition 2 lane, left lane

The middleposition in case of 2-lane feeding for the left lane (seen from the front). Value is in mm.

07 Centerposition 2 lane, right lane

The middleposition in case of 2-lane feeding for the right lane (seen from the front). Value is in mm.

10 Maximum width 1-lane pieces

The maximum width allowed for 1-lane pieces. Pieces which are wider will be dropped. Value is in mm.

11 Maximum width 2-lane pieces

The maximum width allowed for 2-lane pieces. Pieces which are wider will be dropped. Value is in mm.

12 Window for loading position

The tolerance for the position of the clamps when loading new clamps (in the home position). Take care when changing this value. Value is in steps of 0,01mm.

13 General in position window

The general tolerance for the position of the clamps. Take care when changing this value. Value is in steps of 0,01mm.

14 Window for centering piece

The tolerance for the position of the clamps when centering a piece. Take care when changing this value. Value is in steps of 0,01mm.

17 Delay gripper in gripposition

The time the grippers need to get the clamps (from opened position to closed position). Steps of 0,001s.

18 Delay gripper opened from gripposition

The time the grippers need to get away from the clamps (from closed to opened position). Steps of 0,001s.

19 Reverse position laydown beam

The position where the laydown beam reverses after laying down a piece. Steps of 0,001s. Only used in case of laydown beam with 2 direction movement.

20 Releaseposition laydown beam

The position of the laydown beam when piece is released. Steps of 0,001s.

21 Delay start release after beam in pos.

The delay between the moment the beam is in release position and the moment the release cycle starts. Steps of 0,001s.

22 Max. number of empty clamps in a row

The maximum number of empty clamps or pieces in 1 clamp in a row. If this number is exceeded, feeding in will stop. Value 0 disables the watchdog.

23 Activation time belt dropped pieces

The time the conveyor for the dropped pieces is activated in case the suction box is emptied or in case a piece drops out of the clamps. Value is in steps of 10ms (0,01s).

25 Size step outside at release

The distance the carriers move outside after releasing a piece. Used to get the clamps away from the corners of the piece. Distance is in mm.

27 Moment brushes at beam up

The moment the brushes at the laydown beam are sent up when a new piece is layed down onto the belts. Steps of maincountwheel pulses.

28 Time brushes at beam stay up

The time the brushes at the laydown beam are sent up when a new piece is layed down onto the belts. Steps of maincountwheel pulses.

29 Moment brushes at ironer up

The moment the brushes at the ironer are sent up when a new piece is coming. Steps of maincountwheel pulses.

30 Time brushes at ironer stay up

The time the brushes at the ironer will stay up when the front of a new piece passes. Steps of maincountwheel pulses.

31 Releasetime opening clamps

The time the release arms are activated when releasing a piece. Time in 0,001s.

32 Delay new clamps in loading position

The time the photocells in the feeding gate have to be covered before the grippers of the stations will close. Steps of 0,001s.

33 Delay loading gate opened/closed

The time the feeding gate needs to open or close. Steps of 0,001s.

35 Disable station 1

This parameter can be used to disable station 1 in case of a malfunction. Value 1 is station disabled, value 0 is station enabled.

36 Disable station 2

This parameter can be used to disable station 2 in case of a malfunction. Value 1 is station disabled, value 0 is station enabled.

37 Disable feeding on lane

This parameter can be used to disable a lane in case of 2-lane feeding. Value 0 is both lanes enabled, 1 is left lane disabled, 2 is right lane disabled.

38 Wax program for folder

The program which is sent to the folder when the nose moves to service position, for example for waxing. Value 0 disables this option.

39 Program when unknown customer/article

In case a customer separation system is present, and the current customer and/or article is unknown, this program will be used.

40 Standby time

When the machine is in automatic feeding mode, it will switch off when no pieces have been fed for the time adjusted in this parameter. Value is in seconds.

41 Ironerspeed when machine in standby

When the feeder has switched into standby mode, the speed of the ironer will be switched to the value of this parameter (m/min). This can be used to save energy.

42 Waittime startup after ironer stop

When the ironer start up after a stop, this is the time the feeder waits with starting up the main motor. Steps of 0,1s.

43 Run without ironer stop contact

When testing, this parameter can be put to 1. In this case, the machine ignores the ironer stop contact and will run while the ironer is stopped. In normal mode, the value should be 0.

44 Timer ironer 0-speed when folder stops

When the ironer stops, a 0-speed is sent to the ironer during this time (seconds). After that, the normal speed will be applied again.

45 Length of extra buffer before feeder

The time clamps need to get from the railsystem into the extra gate. Steps of 0,1s.

46 Delay full clamp full detection

The time the buffer full detection sensors have to be covered to have a real buffer full detection. Steps of 0,01s.

47 Delay full clamp not full detection

The time the buffer full detection sensors have to be uncovered to cancel the buffer full detection. Steps of 0,01s.

48 Length of buffer before feeder

The time the clamps need to get from the last gate in front of the machine to the feeding gate in the machine. Steps of 0,1s.

50 Ironer length

The length of the ironer in centimeters. Is used for changing speed, changing program and for the reject system.

51 Maximum speed of feeding machine

The speed of the feeding machine when 10 Volts is sent to the inverter. Is the maximum speed the feeding machine can run.

52 Minimum speed of ironer

The speed of the ironer when 0V is sent to the inverter. This is the minimum speed the ironer can run when it's operating.

53 Maximum speed of ironer

The speed of the ironer when 10Volts is sent to the inverter. Is the maximum speed the ironer can run.

54 Maximum speed of folding machine

The maximum speed of the folding machine in steps of 0,1 meters/minute. Is used to be able to control the speed of the folder in the right way.

55 Moment flaps at ironer up

The moment the flaps at the ironer are sent up when a new piece is coming. Value is in millimeters.

56 Time flaps at ironer stay up

The time the flaps at the ironer will stay up when the front of a new piece passes. Value is in millimeters.

60 Pulse size maincountwheel

The size of a pulse of the main countwheel in micrometers. ATTENTION!!! Changing this parameter can cause a complete machine stop.

61 Pulse size ironercountwheel

The size of a pulse of the ironer countwheel in micrometers. ATTENTION!!! Changing this parameter can cause a complete machine stop.

65 Reset counters without password

When this parameter has a value of 1, counters per program can be reset without the need of a password.

67 Usage of button stop call new clamps

The buttonfunction to to stop calling clamps:

0 = Stop new clamps from railsystem.

1 = Stop new clamps from extra gate.

70 CAN-bus stationnumber this PLC

Stationnumber of this PLC. Every PLC in a CAN network has to have a unique stationnumber.

71 CAN-bus baudrate

Baudrate/communication-speed of this PLC. Every PLC in a CAN network has to be adjusted to the same baudrate.

72 Folder with CAN-bus online

Value of 1 means that a folder with CAN-bus is online. In this case the feeder will start to communicate with the folder regarding programnumber and other data.

73 Customer separation system active

Value of 1 means that the customer separation system is activated. Otherwise a value of 0 should be entered.

74 Delay return to home screen

When the main screen is not activated, and the screen isn't used for this time, the main screen will be activated again. Steps of seconds (0=disabled).

75 Customer separation system with PC

Value 1 means that the customer/article database is managed by the PC. Value 0 means that it is managed by this PLC. Don't set to 0 when a PC is present.

76 Gap in case of new customer

In case of a customer change, the stations will wait with feeding in until the previous piece is gone for the here adjusted distance. Steps of wheelpulses.

77 Gap in case of new article

In case of an article change, the stations will wait with feeding in until the previous piece is gone for the here adjusted distance. Steps of wheelpulses.

78 Gap in case of new feeding program

In case of a new feeding program, the stations will wait with feeding in until the previous piece is gone for the here adjusted distance. Steps of wheelpulses.

79 Gap in case of new folding program

In case of a new fold program, the stations will wait with feeding in until the previous piece is gone for the here adjusted distance. Steps of wheelpulses.

80 Gap in case of nr of lanes change

In case of a change of the number of lanes, the stations are blocked until the previous piece is gone for the here adjusted distance. Steps of wheelpulses.

2) Program parameters

2.1) Overview program parameters

01 Reserved
02 Number of lanes
03 Ironer speed
04 Folding program
05 Relative speed feeder (%)
06 Relative speed folder (%)
07 Clamp speed (%)
08 Ironer program
09 Lane to call from railsystem
10 Lifting action on
11 Lifting with roll/venturi
12 Delay start lifting action
13 Moment stop belts
14 Time/distance stop belts
15 Vacuum below belts half power
16 Enable center clutch during spreading
17 Moment start 2nd clamp in pre-spreading
18 Startwidth after centering
19 Delay start spreading after centering
20 Spreading speed during fast spreading
21 Spreading speed during slow spreading
22 Torque during spreading (%)
23 Reserved
24 Stoptime beam at release
25 Distance move clamps inside at release
26 Delay move to homeposition after release
27 Blowtime when clamps go inside
28 Debounce time end of spreading pc.
29 Extra step after end of spreading pc.
30 Shaking times before end of spreading
31 Reserved
32 Reserved
33 Reserved
34 Moment close suction of laydown beam
35 Position beam when starting suction box
36 Delay start blow-in after previous piece
37 Max.number of venturi pulses
38 Delay between venturi pulses
39 Duration of venturi pulse
40 Delay stop venturi after piece in box
41 Feeding roll high speed during blow-in
42 Time in box before laying down
43 Fast feed-in delay after photocell
44 Use lowest photocell for feeding-in
45 Reserved
46 Minimum distance between pieces
47 Maximum piece length
48 Moment stop belts at laydown
49 Time/distance stop belts at laydown
50 Reserved
51 Feed-in waits until previous blown in
52 Empty clamp handling

- 53 Use extra gate for 2nd pair of clamps
- 54 Reserved
- 55 Enable spreading belts frontside
- 56 Enable brushes in suction box
- 57 Enable brushes at laydown beam
- 58 Enable brushes at ironer
- 59 Enable stretch flaps at ironer
- 60 Delay move clamps out at release
- 61 Delay start blowpipe at release
- 62 Number of blowpulses at release
- 63 Blowpulse time on at release
- 64 Time between blowpulses at release
- 65 Reserved
- 66 Reserved
- 67 Reserved
- 68 Reserved
- 69 Reserved
- 70 Reserved

2.2) Program parameters details

02 Number of lanes

The number of lanes in which the machine works in this program. 1 is a 1-lane program, 2 is 2-lane program.

03 Ironer speed

When the machine controls the speed of the ironer, this parameter is the speed of the ironer in m/min.

04 Folding program

When a folder with CAN-bus is online, the folding program which has to be used can be adjusted with this parameter. When this program is selected, the folder will switch to this folding program.

05 Relative speed feeder (%)

The relative speed of the feeding machine in relation to the ironer (%).

06 Relative speed folder (%)

The relative speed of the folding machine in relation to the ironer (%).

07 Clamp speed (%)

The speed of the clamps during operation. Is % of the maximum speed the machine can handle.

08 Ironer program

When the machine can change the program of the ironer, this is the program sent to the ironer.

09 Lane to call from railsystem

The lane to call from the railsystem.

0 = Automatic with program change.

1.8 = Lane nr 1..8

9 = Automatic, no program change.

10 Lifting action on

Enable piece lifting with feeding roll and venturi.

0 = No lifting

1 = Lift, continue spreading

2 = Lift, stop spreading

11 Lifting with roll/venturi

In case of lifting the piece with the feeding roll and the venturi, this is the time the lifting action is done. Time is in steps of 10ms. Venturi cycle times are the usual ones.

12 Delay start lifting action

The delay between the moment the photocell slow spreading is covered and the moment the lifting device is activated. Steps of 0,001s.

13 Moment stop belts

The moment the first bed stops after laying down a piece. Can be used to stretch the front of the piece. Distance in mainwheel pulses.

14 Time/distance stop belts

The time the first bed stops after laying down a piece. Can be used to stretch the front of the piece. Distance in mainwheel pulses.

15 Vacuum below belts half power

Value 0 means that the fans for vacuum below the laydown belts will run at full power. Value 1 means that they will run on 50% power.

16 Enable center clutch during spreading

Value 0 means that the center clutch isn't used, a value of 1 means that the clutch will be activated during spreading.

17 Moment start 2nd clamp in pre-spreading

This parameter is the moment the outer clamp will start after the inner clamps starts to pre-spread the piece. Value is in mm. Value 0 is automatic measurement of the piece width.

18 Startwidth after centering

After pre-spreading both carriers will be centered around the lane center. This parameter is the distance between the carriers after centering. Value is in mm.

19 Delay start spreading after centering

The delay between the carriers are centered and the moment the spreading cycle starts. Steps of 0,001s.

20 Spreading speed during fast spreading

The carrierspeed during the fast spreading cycle (when photocell slow spreading isn't covered). Value is % of maximum carrier speed.

21 Spreading speed during slow spreading

The carrierspeed during the slow spreading cycle (when photocell slow spreading is covered). Value is % of maximum carrier speed.

22 Torque during spreading (%)

The torque the carriers have during spreading. Value is a % of the maximum torque. If the value is 100%, spreading will stop on the photocell and no torque control is used..

24 Stoptime beam at release

The time the laydown beam is stopped when a piece is released onto the laydown beam. Steps of 0,001s.

25 Distance move clamps inside at release

The distance the clamps move inside, just before releasing the piece. Value is in mm.

26 Delay move to homeposition after release

The time between the moment the piece is released and the moment the carriers will start moving again. Steps of 0,001s.

27 Blowtime when clamps go inside

The time the blowpipe for blowing the piece onto the beam is activated when the clamps move inside just before releasing the piece. Steps of 0,001s.

28 Debounce time end of spreading pc.

The time the end of spreading photocell has to be covered until the laydown beam will be started to pick up the piece. Steps of 0,001s.

29 Extra step after end of spreading pc.

After the end of spreading photocell is covered, the carriers will continue spreading for this distance. Value is in mm.

30 Shaking times before end of spreading

The number of times the clamps will move left and right before completely spreading the piece. This will only work when the lifting device is switched off.

34 Moment close suction of laydown beam

The delay between the moment the laydown cycle starts and the moment the suction of the laydown beam is closed. Steps of 0,001s. A value of 0 means that the suction will not be closed.

35 Position beam when starting suction box

The position in which the laydown beam waits until the piece is blown into the suction box.

36 Delay start blow-in after previous piece

The distance the backside of the previous piece has to be out of the suction box before the next piece is allowed to go into the box. Distance in steps of main countwheel pulses.

37 Max.number of venturi pulses

The maximum number of venturi pulses. Only used in case the piece doesn't go into the suction box.

38 Delay between venturi pulses

The time between 2 venturi pulses. Steps of 0,001s.

39 Duration of venturi pulse

The time the venture valves are activated. Steps of 0,001s.

40 Delay stop venturi after piece in box

The delay between the moment the front photocell is uncovered (piece completely in suction box) and the moment the venturi stops. Steps of 0,001s.

41 Feeding roll high speed during blow-in

A value of 1 means that the feed-in roll will run at high speed during blowing in. A value of 0 means low speed.

42 Time in box before laying down

The delay between the moment the venturi starts to get the piece into the suction box and the moment the laydown beam lays down the piece. Steps of 0,001s.

43 Fast feed-in delay after photocell

When the value is 0, feed-in will wait until the venturi is finished. Otherwise this is the delay feeding in next piece after the front photocell is uncovered. Steps of 0,001s.

44 Use lowest photocell for feeding-in

When the value is 1, the lowest photocell will be used to feed-in the next piece. Otherwise the 2nd lowest one is used.

46 Minimum distance between pieces

The distance the backside of the previous piece has to be out of the suction box before the next piece is layed down on the conveyor.

47 Maximum piece length

The maximum length of a piece in main countwheel pulses. Is used when piece doesn't go into the suction box.

48 Moment stop belts at laydown

The moment the belts are stopped when the piece is layed down. Is used to get the piece from the laydown beam. Value is in milliseconds from the moment the laydown cycle starts.

49 Time/distance stop belts at laydown

The distance the belts are stopped when the piece is layed down. Is used to get the piece from the laydown beam. Value is in millimeters.

51 Feed-in waits until previous blown in

If this parameter is set to 0, the gate takes out new clamps before the previous piece is blown in. Otherwise carriers wait for blow-in in gate.

52 Empty clamp handling

Handling of empty clamps after releasing piece:

0 = Only release grippers

1 = Swing to feed-out side

2 = Bring to homeposition

3 = Bring to feed-out side

53 Use extra gate for 2nd pair of clamps

If this parameter is set to 1, the gate for fast pushing in of the 2nd pair of clamps at the feed-in side will be used. Otherwise the gate is not used.

55 Enable spreading belts frontside

A value of 1 means that the spreading belts in the suction box will be used. To disable these spreading belts, put this parameter on 0.

56 Enable brushes in suction box

A value of 1 means that the brushes in the suction box will be used. To disable the brushes in the suction box, put this parameter on 0.

57 Enable brushes at laydown beam

A value of 1 means that the brushes at the laydown beam will be used. To disable the brushes at laydown beam, put this parameter on 0.

58 Enable brushes at ironer

A value of 1 means that the brushes at the ironer will be used. To disable the brushes at the ironer, put this parameter on 0.

59 Enable stretch flaps at ironer

A value of 1 means that the flaps at the ironer will be used. To disable the flaps at the ironer, put this parameter on 0.

60 Delay move clamps out at release

The delay between starting the release arms and moving the clamps outside when a piece is released. Steps of 0,001s.

61 Delay start blowpipe at release

The delay between starting the release arms and the moment the pulsetrain of the blowpipes starts to blow the piece on the laydown beam. Steps of 0,001s.

62 Number of blowpulses at release

The number of pulses the blowpipe for blowing the piece on the laydown beam is activated when releasing a piece.

63 Blowpulse time on at release

The time the blowpipe for blowing the piece on the laydown beam is activated during one pulse. Steps of 0,001s.

64 Time between blowpulses at release

The time between 2 pulses for blowing the piece on the laydown beam. Steps of 0,001s.

3) Alarms

001 EMERGENCY STOP

One of the emergency stops on the machine is/has been pushed. When no emergency switch is active anymore, the emergency stop can be reset with the 'reset' button.

003 VARAN-BUS ERROR

The connection with one or more backplanes on the varan IO-bus is lost. As soon as connection is re-established, message will disappear.

004 SERVO 1 OFFLINE

The servo controller of station 1 is offline. Check connection with controller. If necessary, disable station 1 in the machine parameters.

005 SERVO 2 OFFLINE

The servo controller of station 2 is offline. Check connection with controller. If necessary, disable station 2 in the machine parameters.

006 MOTOR THERMICAL OFF

The thermal protection of one of the motors is active. Check if the concerning motor is jammed and release the protection again.

009 ERROR INVERTER / OVERHEAT

One of the inverters is in alarm or one of the motors connected is overheated. Reset of inverter can be done by e-stop and wait. Overheat will reset after cooling down.

010 ERROR INVERTER CARRIERS

One of the inverters of the carriers is in alarm, or the motor is overheated. Reset of inverter can be done by emergency stop and wait. Overheating will reset after cool down (Check LED-terminals).

011 ERROR INVERTER/MOTOR

One of the inverters is in alarm, or a thermal protection of one of the motors has been activated, or one of the motors gives an overheat signal.

015 TIME-OUT BEAM MOVEMENT

During moving the laydown beam the proximity switch for the pick-up position wasn't detected in the estimated time. Check movement and prox. switch.

016 TIME-OUT BEAM MOVEMENT

During moving the laydown beam the proximity switch for the rest position wasn't detected in the estimated time. Check movement and prox. switch.

021 ERROR AXIS 1

The inner axis of the front station gives an error. Please check the connections between the motor and the servo amplifier. Switch machine on and off for restart.

022 ERROR AXIS 2

The outer axis of the front station gives an error. Please check the connections between the motor and the servo amplifier. Switch machine on and off for restart.

023 ERROR AXIS 3

The inner axis of the rear station gives an error. Please check the connections between the motor and the servo amplifier. Switch machine on and off for restart.

024 ERROR AXIS 4

The outer axis of the rear station gives an error. Please check the connections between the motor and the servo amplifier. Switch machine on and off for restart.

026 DRAG LIMIT STATION 1

The position of a carrier of station 1 doesn't match the expected position. This can be caused by a jammed carrier. Check this and restart the machine.

027 DRAG LIMIT STATION 2

The position of a carrier of station 2 doesn't match the expected position. This can be caused by a jammed carrier. Check this and restart the machine.

033 Ironer stopped

The contact that the ironer is stopped isn't made. Because of this contact, the main motor is not allowed to run.

034 Fans suction box overheated

One of the fans in the suction box gives an overheat signal. Message can be reset with the start button when the overheat contact is not active anymore.

035 Nose not in position

The feed-out nose is not in the home position.

036 Air pressure too low

The air pressure switch has detected that the air pressure is too low.

037 Thick piece detected

The switch for thick pieces on the feeding-nose is activated. This can be caused by a wrinkled piece or a pillow case in a duvet cover. To protect the ironer, the conveyor is stopped.

040 Time-out extra gate

The homeposition prox. switch of the extra full clamp motorgate wasn't detected in the estimated time. Check movement of gate and prox. switch.

041 One clamp in gate

In the extra full clamp motorgate, only 1 clamp is detected. This can indicate an odd number of clamps in the gate.

044 Empty clamps stuck

No empty clamps did come out of the chain of the empty clamps for too long. This can be caused by a jam at the empty clamp exit.

045 Empty clamps full

The buffer of the empty clamps is full.

046 Odd clamps at feed-in

At the feed-in gate, only 1 of the 2 photocells is covered. This can be caused by clamps which are not in the gate well, or by an odd number of clamps in the machine.

047 Too many releases on maximum

The maximum number of pieces released at maximum spreading is reached. This can be caused by an odd number of clamps at the feed gate. Reset with startbutton.

050 Frontphotocell covered

The stations are not allowed to feed-in because there is still a piece in front of the machine (one of the front photocells covered).

051 Suction box not empty

The photocell which detects dropped pieces in the suction box is still covered, despite the fact that the machine tried to empty the box.

056 CAN-bus send error

An error occurred during sending of data by the CAN-bus. This can be caused by a wrong connection to the other machines.

060 Ironer stop disabled

The ironer stop contact isn't made, so the ironer isn't running, but this contact is disabled by the machine parameter for ignoring the ironer stop.

065 Battery almost empty

The battery in the PLC is almost empty. It has to be replaced every year. Replace the battery as soon as possible to prevent loss of data.

066 CPU temperature too high

The temperature of the PLC-processor is too high. Reason can be a broken fan or a too high environment temperature.

075 Creating gap

The machine is waiting so a gap is created between this piece and the previous piece.

076 New program in ironer

On the feeding side, a new program has been chosen. This program change is now delayed through the ironer. After the program is switched, this notification will disappear.

078 Emptying extra rail

Because of a program change, or a customer/article change, the extra buffer before the feeder has to be emptied. When the rail is empty the message will disappear.

079 Emptying feeder

Because of a program change, or a customer/article change, the feeder has to be emptied. When the feeder is empty, the message will disappear.

080 Machine in standby

During the adjusted standby time, the machine hasn't been used. When new clamps arrive in the machine, or when the startbutton is pushed, the machine will restart.

083 Waiting for start

The machine is waiting for a start signal to be given by the startbutton on this touchscreen.

085 Operating

The machine is running, no alarms or other notifications.