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MDI_P1R44F-009 : Installer Manual

1. Informations

1.1 Release



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Release documento	Description	Note	Data
01	New manual		30/11/2022

Specifications

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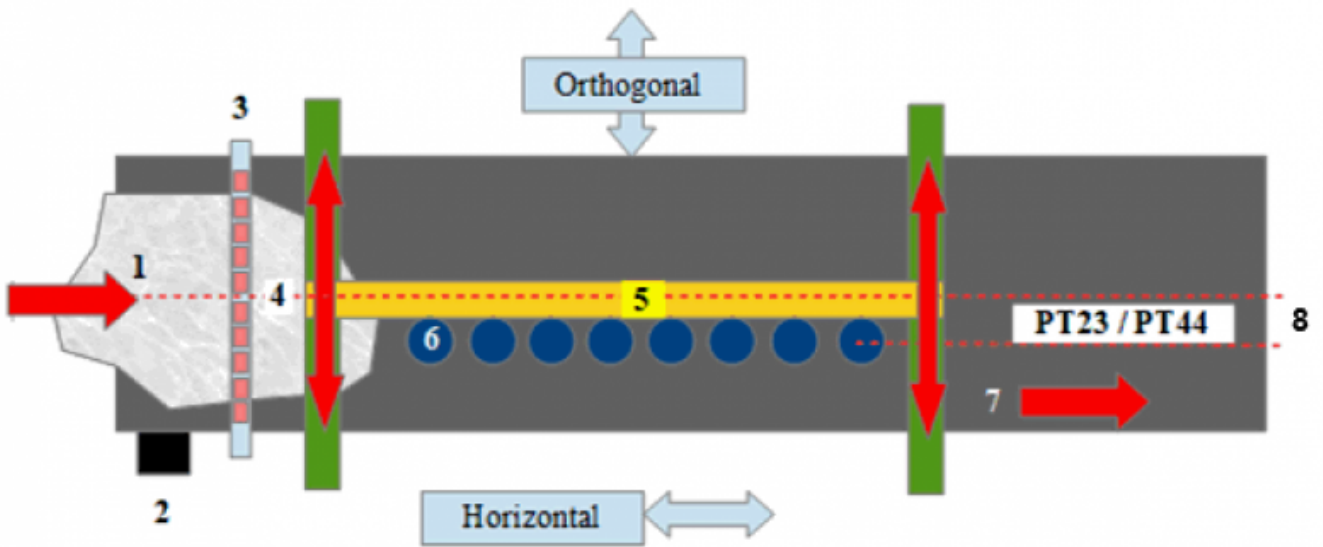
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2. Setup

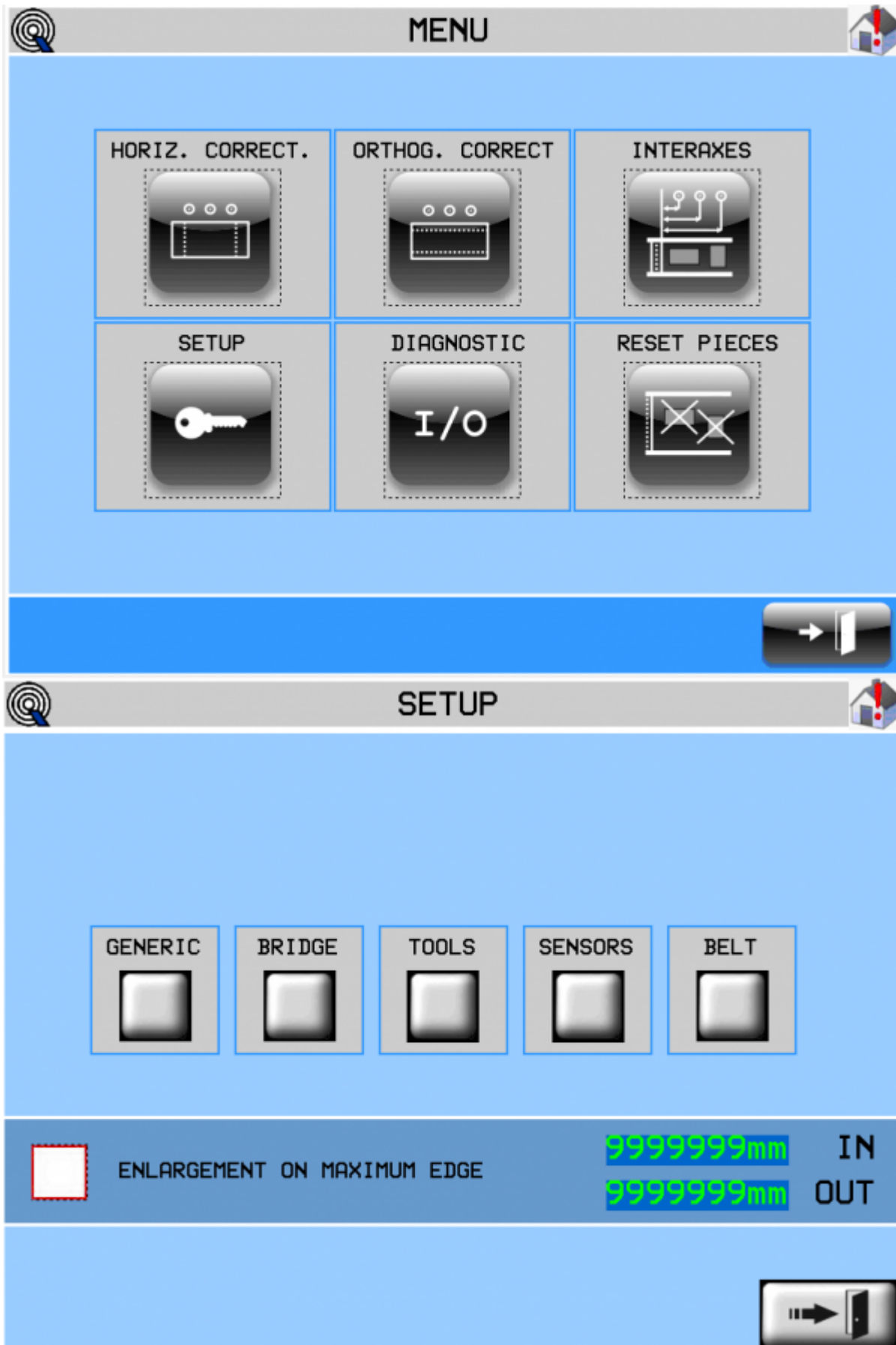
Machine view from above:



n:	Description:
1	Raw slab
2	Tape Encoder
3	Limit sensor bar
4	Center of the sensors / centre of the bridge axis travel
5	Bridge
6	Polishing heads
7	Belt direction
8	Orthogonal Offset






2.1 Setup access

Access to setup can be done from the MENU page, by entering the password **035**.




2.1.1 SETUP Introduction


Parameter list divided into

GENERIC 	generic parameters
BRIDGE 	parameters associated with the bridge
TOOLS 	parameters associated with heads
SENSORS 	parameters associated with the sensor bar
BELT 	parameters associated with the conveyor belt
ENLARGEMENT ON MAXIMUM EDGES:	allows you to polish the horizontal edges better. This parameter is useful when you're working with fairly straight edges (not jagged)

2.2 Generic Setup




GENERIC



PG01: LANGUAGE	ENG	PG16: TIME PRE-START	999999 s
PG02:		PG17: LUBRIF. TIME ON	999999 s
PG03: DECIMAL POINT	99999	PG18: LUBRIF. TIME OFF	999999 s
PG04:		PG19: ENGINES TIME ON	999999 s
PG05: ORTHOGONAL STEP	9999999 mm	PG20: ENGINES TIME OFF	999999 s
PG06: HORIZONTAL STEP	9999999 mm	PG21: TIME ENGINE OFF	
PG07:		ON EXIT BELT	999999 s
PG10: SLAB IN	LF	PG25: HEADS OUTPUT	ON
PG11: AUTOAPPR. PONTE	ON	PG26: LINE OUTPUT	ON
PG12:		PG27: PULSE TIME	999999 s
PG13: OPERATOR SIDE	OFF	PG29:	
PG14:		PG30: BRUSH EARLY	9999999 mm
PG15: SELECTOR AUTO/MAN	ON	PG31: BRUSH DELAY	9999999 mm
GENERIC BELT SETUP		PG32: REFERENCE VEL	9999999 m/
PG08: LINE MEASURE	9999999 mm	PG33:	
PG09: LINE PULSE	9999999	PG34: RAMP TYPE	LINEAR
PG28: LINE DELAY	9999999 s	PG35: HEAD SEGMENTATION	4
PG36: MAX SET SPEED	99999 m/min		
PG37: MIN SET SPEED	99999 m/min		

99 : 99 : 99
99 / 99 / 9999



Parameter name	Unit of measure	Default	Range	Description
PG01 : LANGUAGE	-	ITA	1 ÷ 2	1: ITALIAN 2: ENGLISH
PG03 : DECIMAL POINT	-	1	0 ÷ 3	It is the position of the decimal point in the quotas display.
PG05 : ORTHOGONAL STEP	mm	50.0	-	Distance between the limit switches of the sensor bar. It acquires the shape of the slab.
PG06 : HORIZONTAL STEP	mm	50.0	-	Space set by encoder. It acquires the shape of the slab.
PG08 : LINE MEASURE	mm	1	0 ÷ 999999	Indicates the space, in units of measurement, covered by the conveyor belt to obtain the encoder pulses set on the <i>pulse</i> parameter.
PG09 : LINE PULSE	-	1	0 ÷ 999999	Indicates the pulses multiplied by 4 provided by the conveyor belt encoder to obtain the space set in the <i>measure</i> parameter. <i>The ratio between measure and pulse is the resolution of the encoder and must have values between 1 and 0.000935.</i>
PG11 : SELF-LEARNING. BRIDGE	-	OFF	0 ÷ 1	Enables the self-learning option of the minimum and maximum height of the slab to optimize the swiveling of the bridge.
PG13 : OPERATOR SIDE	-	FWD	0 ÷ 1	Indicates at the cycle stop event where the bridge must be positioned. FWD = on the maximum quota, BWD = on the minimum quota.
PG15 : AUTO / MAN SELECTOR	-	ON	0 ÷ 1	Enable manual / automatic selector.
PG16 : PRESTART TIME	s	3.0	0 ÷ 9999.9	Time between the start command and the actual starting of the machine (the warning signal is active during this time). If it's less than the motor activation time, the greater time of the two is applied.
PG17 : LUBRIF. TIME ON	s	0.0	0 ÷ 9999.9	Lubrication output time ON.
PG18 : LUBRIF. TIME OFF	s	0.0	0 ÷ 9999.9	Lubrication output time OFF.
PG19 : ENGINES TIME ON	s	1,000	0 ÷ 99.999	Pause time between the activation of one motor and the next (in sequential activation).
PG20 : ENGINES TIME OFF	s	0.200	0 ÷ 99.999	Pause time between the deactivation of one motor and the next (in sequential deactivation).
PG21 : TIME ENGINE OFF ON EXIT BELT	s	0.000	0 ÷ 99.999	Waiting time to start the sequential deactivation of the motors, starting when there are no more pieces on the belt.

Parameter name	Unit of measure	Default	Range	Description
PG25 : HEAD OUTPUT	-	CONST	CONST ÷ PULSE	Operating mode of the head activation output. CONST = the output remains active for the entire time the head is used, PULSE = the output remains active for a set time (PG27).
PG26 : LINE OUTPUT	-	CONST	CONST ÷ PULSE	Operating mode of the conveyor belt activation output. CONST = the output remains active for the entire time the conveyor belt is used, PULSE = the output remains active for a set time (PG27).
PG27 : PULSE TIME	s	0.000	0 ÷ 99.999	Activation time of the head and conveyor belt outputs if they are enabled as impulsive.
PG28 : LINE DELAY	s	0.000	0 ÷ 99.999	Conveyor belt activation delay time after the bridge has started.
PG30 : BRUSH EARLY	mm	0.0	-9999.9 ÷ 9999.9	Advance space for brush descent.
PG31 : BRUSH DELAY	mm	0.0	-9999.9 ÷ 9999.9	Delay space for brush ascent.
PG32 : REFERENCE VEL	m / '	0.0	0 ÷ 9999.9	Reference speed for the use of the advances and delays of the brush. If set to 0, no speed proportion is made but the set quotas are used.
PG34 : RAMP TYPE	-	1	0 ÷ 1	Type of ramp. 0 = linear ramp. 1 = S ramp

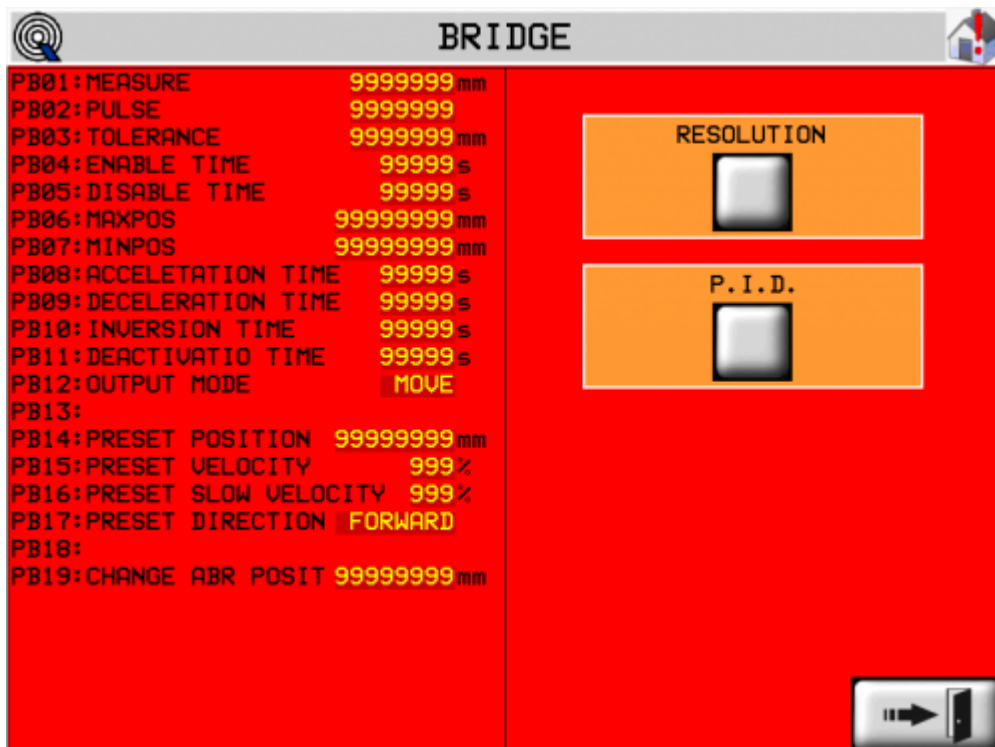
2.3 Setup Belt

Belt axis resolution



Parameter name	Unit of measure	Default	Range	Description
MEASURE	mm	0.1	0 ÷ 99999.9	Indicates the space, in units of measure, covered by the tape to obtain the encoder pulses set on the <i>pulse</i> parameter.
PULSE	-	1	0 ÷ 999999	Indicates the pulses multiplied by 4 provided by the tape encoder to obtain the gap set in the measure parameter. The ratio between measure and pulse is the resolution of the encoder and must have values between 1 and 0.000935.



2.4 Setup Bridge



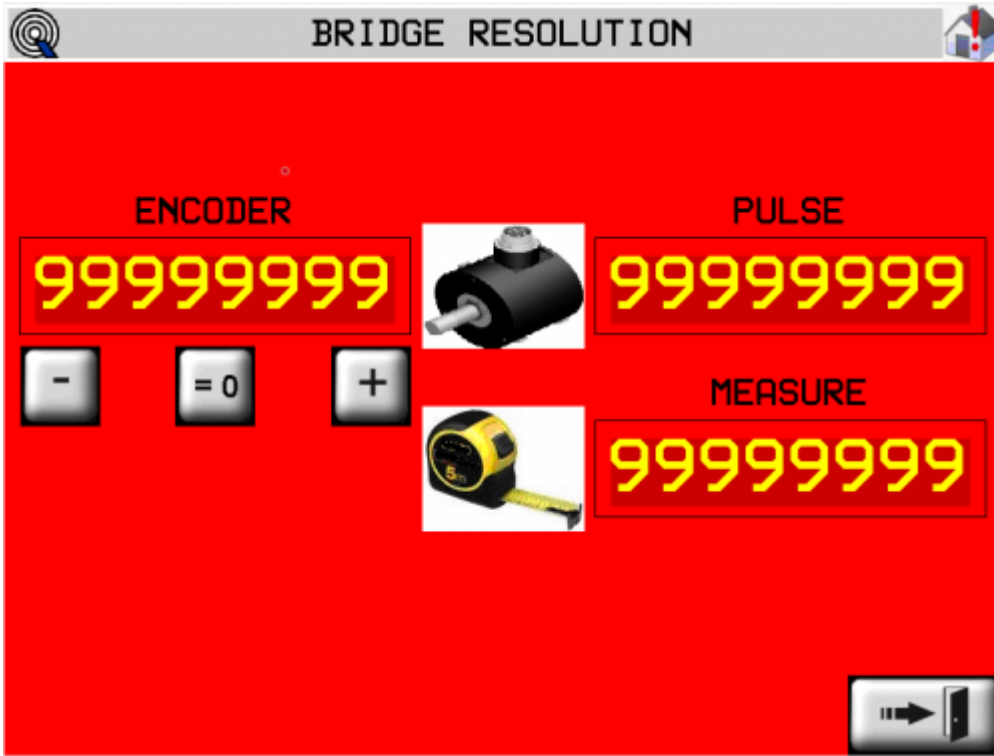
Parameter name	Unit of measurement	Default	Range	Description
PB01 : MEASURE	mm	0.1	0 ÷ 99999.9	Indicates the space, in units of measure, covered by the bridge to obtain the encoder pulses set on the <i>pulse</i> parameter.
PB02 : PULSE	-	1	0 ÷ 999999	Indicates the pulses multiplied by 4 supplied by the encoder of the bridge to obtain the space set in the parameter <i>measure</i> . The ratio between measure and pulse is the resolution of the encoder and must have values between 1 and 0.000935.
PB03 : TOLERANCE	mm	5.0	0 ÷ 99999.9	It defines a count range around the positioning quotas. If the positioning ends within this range, it is correct.
PB04 : ENABLE TIME	s	0.200	0.000 ÷ 9.999	Bridge movement activation advance.
PB05 : DISABLE TIME	s	0.200	0.000 ÷ 9.999	Bridge movement deactivation delay.
PB06 : MAXIMUM QUOTA	mm	99999.9	-99999.9 ÷ 99999.9	Maximum quota reachable from the bridge.
PB07 : MINIMUM QUOTA	mm	-99999.9	-99999.9 ÷ 99999.9	Minimum quota reachable from the bridge.
PB08 : ACCELERATION TIME	s	1.00	0.00 ÷ 9.99	It is the time required to pass from 0 speed to maximum speed.
PB09 : DECELERATION TIME	s	1.00	0.00 ÷ 9.99	It is the time needed to go from maximum speed to 0 speed.
PB10 : INVERSION TIME	s	0.50	0.00 ÷ 9.99	It is used to avoid mechanical stress due to rapid reversals of the movement direction
PB11 : DEACTIVATION TIME	s	0	0 ÷ 99999	Rest time of the bridge after which the enabling output of the axis is deactivated.
PB12 : OUTPUT MODE	-	STILL	MOVE, STILL	Axis enable output operating mode. MOVE : The output activates before the movement of the axis and deactivates after this has finished, according to the times set on parameters PB04 and PB05. STILL : The output activates before movement and deactivates only when the state passes to emergency.
PB14 : PRESET POSITION	mm	0.0	-99999.9 ÷ 99999.9	Quota loaded on the count when the axis activates and then releases the Homing sensor.
PB15 : PRESET VELOCITY	%	5	1 ÷ 100	It is the homing sensor search speed.
PB16 : PRESET SLOW VELOCITY	%	2	1 ÷ 100	It is the speed for the release of the homing sensor.
PB17 : PRESET DIRECTION	-	BACKWARD	FORWARD, BACKWARD	Direction to search for the homing sensor.
PB19 : CHANGE ABR POSITION	mm	0.0	-99999.9 ÷ 99999.9	Bridge positioning value when it is requested to interrupt the cycle to change the abrasive.

2.4.1 Calibrations

The calibration pages are divided into:

	setting the resolution of the axis
	axis calibration procedure for adjusting the feedback and for setting the offset and maximum speed

Bridge axis resolution



Parameter name	Unit of measure	Default	Range	Description
MEASURE	mm	0.1	0 ÷ 99999.9	Indicates the space, in units of measure, covered by the tape to obtain the encoder pulses set on the <i>pulse</i> parameter.
PULSE	-	1	0 ÷ 999999	Indicates the pulses multiplied by 4 provided by the tape encoder to obtain the gap set in the measure parameter. The ratio between measure and pulse is the resolution of the encoder and must have values between 1 and 0.000935.

Bridge calibration

BRIDGE TUNING

CALIBRATION
OFF

VOLTAGE OUTPUT 99999999 V

OFFSET 99999999 V

A
OFF

-

+

VELOCITY 99999999 mm/s
99999999 Hz

MAX VELOCITY 99999999 mm/s

POSITION = 0 99999999 mm
99999999999

POSITIONER
STOP

DELTA 99999999 mm

SET VELOCITY 99999999 mm/s

ACC. TIME 99999999 s

DEC. TIME 99999999 s

FEEDFORWARD 99999999 %

PROP. GAIN 99999999

INTEGRAL TIME 99999999 s



MAX FOLL. ERROR 99999999 mm

FOLLOW ERROR 999999999999 mm


FEEDFORWARD REGISTRY 999999999999
 PROPORTIONAL REGISTRY 999999999999
 INTEGRAL REGISTRY 999999999999

Parameter name	Unit of measurement	Default	Range	Description
VOLTAGE OUTPUT	V	0.0	-10.0 ÷ 10.0	Control voltage Inverter/Driver
OFFSET	V	0.0000	-99.9999 ÷ 99.9999	Voltage value to obtain from the analog output 0 Volt
VELOCITY	mm/'	-	-	Speed of the bridge
MAX VELOCITY	mm/'	5000	0 ÷ 9999999	Speed of the bridge with the 10 Volt command
POSITION	mm	-	-	Bridge position
DELTA	mm	0.0	-	Bridge swing space
SET VELOCITY	mm/'	0	-	Speed of the bridge
ACC TIME	s	0.00	-	Acceleration time
DEC TIME	s	0.00	-	Deceleration time
FEEDFORWARD	%	100.0	0.0 ÷ 200.0	It is the percentage coefficient which, multiplied by the speed, generates the feed-forward part of the regulation output.
PROP. GAINS	-	0.000	0.000 ÷ 9.999	It is the coefficient which, multiplied by the following error, generates the proportional part of the regulation output.
INTEGRAL TIME	s	0.000	0.000 ÷ 9.999	It is the time that produces the integration coefficient of the following error. The integration of this error multiplied by this coefficient generates the integral part of the regulation output.
MAX FOLLOW ERROR	mm	99.9	0.0 ÷ 99999.9	Defines the maximum acceptable deviation between the theoretical position and the real position of the axis, beyond which an alarm is generated
FOLLOW ERROR	mm	-	-	It is the instantaneous value of the following error.

2.5 Setup Tools

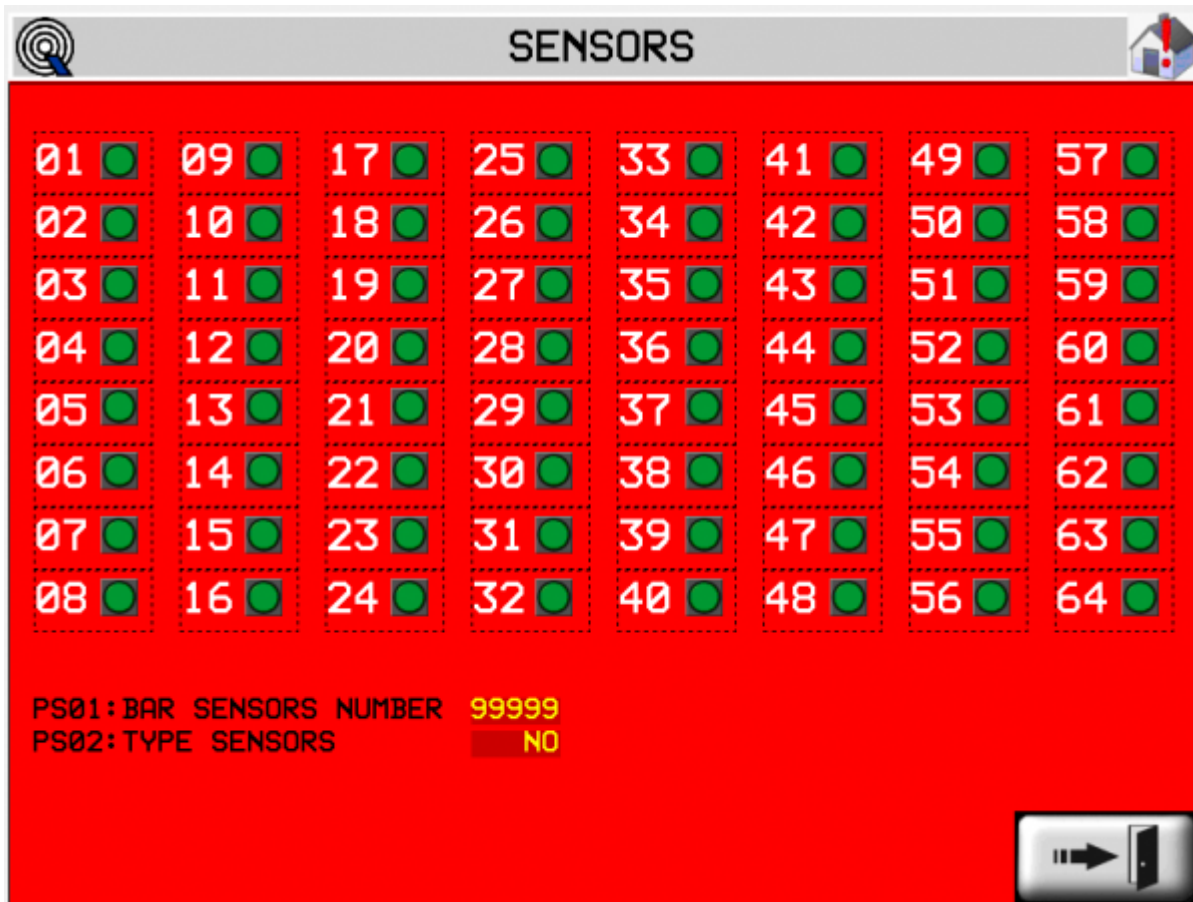

TOOLS


	DIAMETER	ORTHOGONAL OFFSET	TIME TO PARTIAL LIFT
1	PT01: 9999999 mm	PT23: 9999999 mm	PT45: 9999999 s
2	PT02: 9999999 mm	PT24: 9999999 mm	PT46: 9999999 s
3	PT03: 9999999 mm	PT25: 9999999 mm	PT47: 9999999 s
4	PT04: 9999999 mm	PT26: 9999999 mm	PT48: 9999999 s
5	PT05: 9999999 mm	PT27: 9999999 mm	PT49: 9999999 s
6	PT06: 9999999 mm	PT28: 9999999 mm	PT50: 9999999 s
7	PT07: 9999999 mm	PT29: 9999999 mm	PT51: 9999999 s
8	PT08: 9999999 mm	PT30: 9999999 mm	PT52: 9999999 s
9	PT09: 9999999 mm	PT31: 9999999 mm	PT53: 9999999 s
10	PT10: 9999999 mm	PT32: 9999999 mm	PT54: 9999999 s
11	PT11: 9999999 mm	PT33: 9999999 mm	PT55: 9999999 s
12	PT12: 9999999 mm	PT34: 9999999 mm	PT56: 9999999 s
13	PT13: 9999999 mm	PT35: 9999999 mm	PT57: 9999999 s
14	PT14: 9999999 mm	PT36: 9999999 mm	PT58: 9999999 s
15	PT15: 9999999 mm	PT37: 9999999 mm	PT59: 9999999 s
16	PT16: 9999999 mm	PT38: 9999999 mm	PT60: 9999999 s
17	PT17: 9999999 mm	PT39: 9999999 mm	PT61: 9999999 s
18	PT18: 9999999 mm	PT40: 9999999 mm	PT62: 9999999 s
19	PT19: 9999999 mm	PT41: 9999999 mm	PT63: 9999999 s
20	PT20: 9999999 mm	PT42: 9999999 mm	PT64: 9999999 s
21	PT21: 9999999 mm	PT43: 9999999 mm	PT65: 9999999 s
22	PT22: 9999999 mm	PT44: 9999999 mm	PT66: 9999999 s

PT68: LIFT DELAY
9999999 s


Parameter name	Unit of measurement	Default	Range	Description
PT01 / PT22 : DIAMETER	mm	0.0	0 ÷ 99999.9	Head diameter.
PT23 / PT44 : ORTHOGONAL OFFSET	mm	0.0	0 ÷ 99999.9	It is the distance between the working head and the midline of the bridge.
PT45 / PT66 : TIME TO PARTIAL LIFT	s	0.500	0 ÷ 999.999	It is the activation time of the output for the partial ascent.
PT68 : LIFT DELAY	s	0.000	0 ÷ 999.999	Delay for the total ascent of the heads.

2.6 Setup Sensors



Parameter name	Unit of measure	Default	Range	Description
PS01 : SENSORS NUMBER	-	32	8 ÷ 64	Number of sensors present on the acquisition bar.
PS02 : SENSORS TYPE	-	NO	NO ÷ NC	Slab Acquisition Input Logic. NO = Normally Open NC = Normally Closed

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