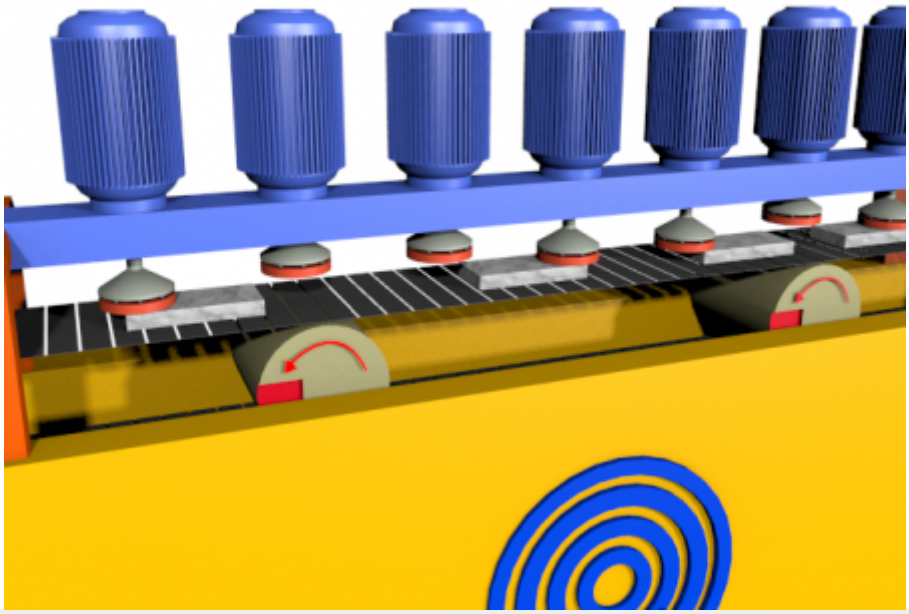
Índice

P1P20FH20 - 001 : Installation Manual 3
Contents 4
1. Description 5
2. Hardware J1-P20-FH20 6
2.1 Standard Symbols & Buttons 7
2.2 MAIN SCREEN 7
3. Startup 8
4. Setup 9
4.1 HMI Setup 10
4.2 General Parameters - GP 11
4.3 Machine Parameters - MP 12
4.4 Calibration 13
4.4.1 Belt resolution 14
4.4.2 Maximum Belt Speed calibration 15
4.4.3 Head Calibration 15
4.4.4 Slab IN limit switch offset 17
4.4.5 Dynamic head Up/Down correction 18
5. Diagnostic 20
5.1 Digital Input diagnostic 21
5.2 Digital Output diagnostic 21
5.3 Operating Diagrams 22
5.4 Belt encoder count 22
5.5 Analog Inputs and Outputs 22
5.6 System Info 22
6. Alarms 24
6.1 Alarm list 24
6.2 Alarm history 25
7. Warnings 25
8. Typical wiring diagram 26

P1P20FH20 - 001 : Installation Manual



Document	**MDI_P1P20FH20-001**
Description	Installation Manual
Drawn up by	Michele Sandri
Approved by	Gabriele Bazzi
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	http://www.qem.eu/doku/doku.php/strumenti/qmoveplus/j1p20/mimj1p20fx
Language	English

Document Release	Description	Notes	Date
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Contents

- 1.Description
- 2. Hardware J1-P20-FH20
- 2.1. Standard Symbols & Buttons
- 2.2. MAIN SCREEN
- 3. Startup
- 4. Setup
- 4.1. HMI Setup
- 4.2. General Parameters - GP
- 4.3. Machine Parameters - MP
- 4.4. Belt and Head Calibrations
- 4.5. Calibration
- 4.5.1. Belt resolution
- Axis Resolution
- 4.5.2. Maximum Belt Speed calibration
- 4.5.3. Head Calibration
- 4.5.4. Slab IN limit switch offset
- 4.5.5. Dynamic head Up/Down correction
- 5. Diagnostic
- 5.1. Digital Input diagnostic
- 5.2. Digital Output diagnostic
- 5.3. Operating Diagrams
- 5.4. Belt encoder count
- 5.5. Analog Inputs and Outputs
- 5.6. System Info
- 6. Warnings
- 7. Alarms
- 7.1. Alarm list
- 7.2. Alarm history
- 8. Typical wiring diagram

1. Description

Il software **P1P20FH20 - 001**, installato nell'hardware *Qmove **J1-P20-FH20***, realizza l'automazione di macchine **levigatrici/levigabordi** .

Caratteristiche principali

- lo strumento comanda **19 teste** di lavoro
- controlla l'**avviamento sequenziale dei motori** (per limitare l'eccessivo richiesta di corrente)
- gestisce l'eventuale **spostamento del ponte**
- per ogni testa di lavorazione è possibile impostare gli **anticipi e i ritardi di lavorazione**, sia all'**inizio**, sia alla **fine** del pezzo
- I comandi di salita/discesa delle teste di levigatura, vengono calcolati **automaticamente al variare della velocità** del nastro trasportatore.
- lo strumento conta i **metri lavorati** ed è in grado di lavorare fino a **30 pezzi** presenti contemporaneamente in macchina.

Altre Caratteristiche

- HMI con touchscreen
- Tasti funzione
- Programmi di lavoro
- Messaggi di allarme
- Messaggi di warning
- Reset dei pezzi difettosi
- Reset di tutti i pezzi in lavorazione
- Compensazione dell'offset del finecorsa di presenza pezzo
- Modo di lavorazione delle teste
    1. Levigatura
    2. Fresatura
    3. Molatura
    4. Spazzolatura
    5. Getto d'acqua

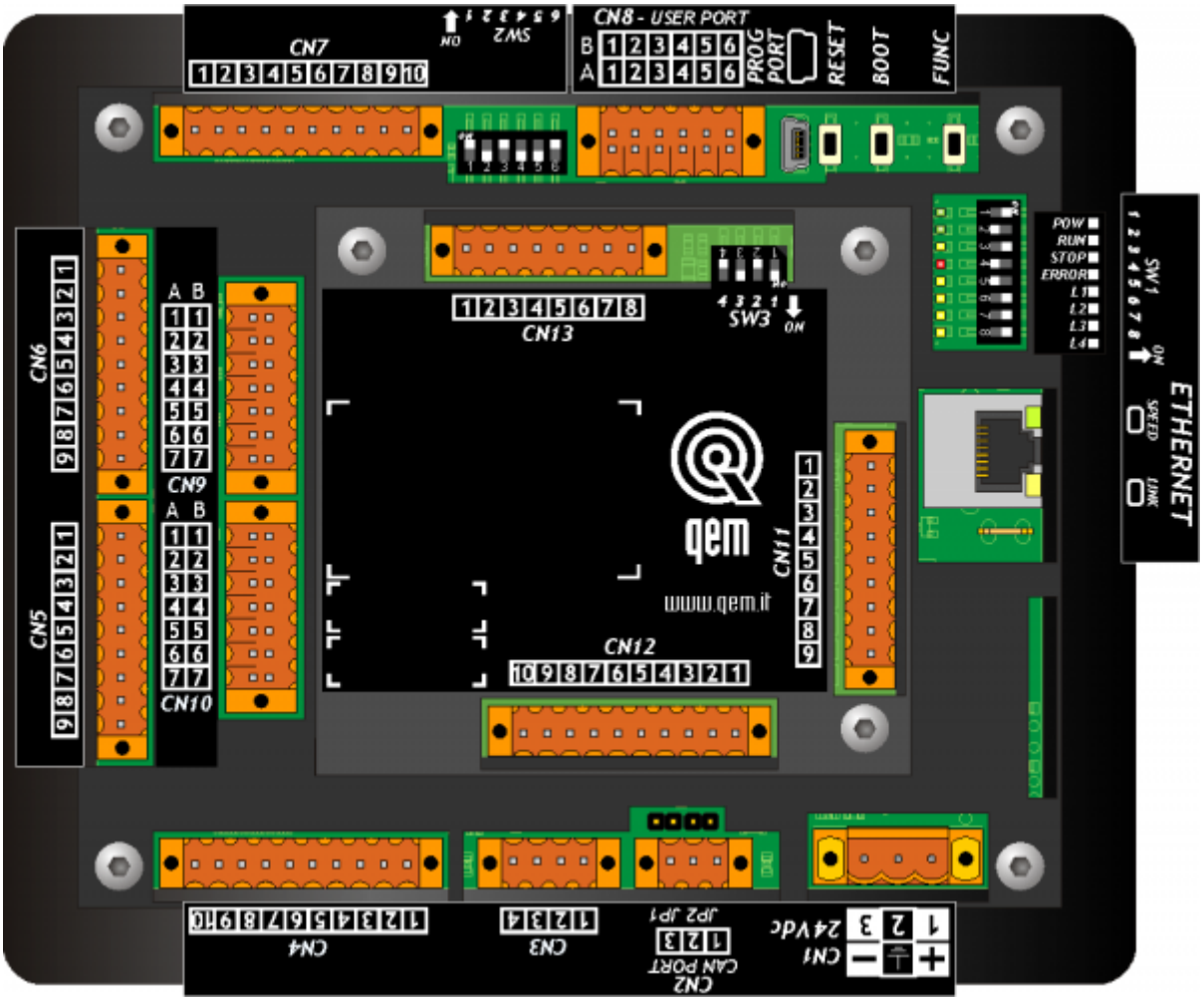
Opzioni e caratteristiche di possibile futura implementazione

- Con l'installazione dei moduli RMC1XX sarà possibile automatizzare **2 o 4 calibratori**
- Con l'installazione dei moduli RMC1YY sarà possibile leggere la **corrente di ogni testa**
- E' possibile dotare lo strumento del software necessario per realizzare delle **lavorazioni di bocciardatura**
- E' possibile dotare lo strumento di funzionalità software di **abilitazione/disabilitazione di ogni singola testa**
- E' possibile dotare lo strumento di porta **Etnernet, che consente di trasmettere i dati della macchina** agli uffici di programmazione della produzione .
- **Risparmio energetico :** accensione dei motori solo durante la lavorazione
  Nota : in questo caso si dovrà utilizzare un modulo di espansione degli I/O

Note Se il cliente è interessato a queste opzioni e caratteristiche, oppure altre di Sua scelta, contattare l'Ufficio Commerciale della QEM (info@qem.it)

2. Hardware J1-P20-FH20

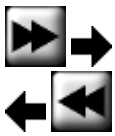
F1	MAIN MENU
F2	RESERVED SETUP (enter password)
F3	WORK PROGRAMS
F4	RESET ALL SLABS
F5	RESET SELECTED SLABS
F6	ALARMS
F7	ESC TO PREVIOUS SCREEN

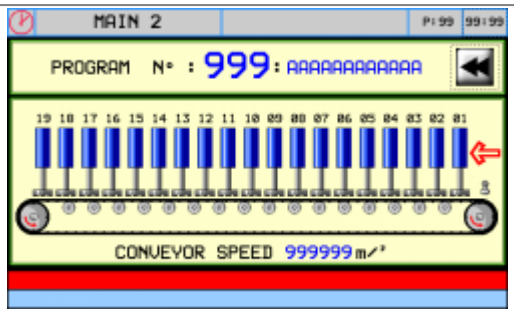


2.1 Standard Symbols & Buttons

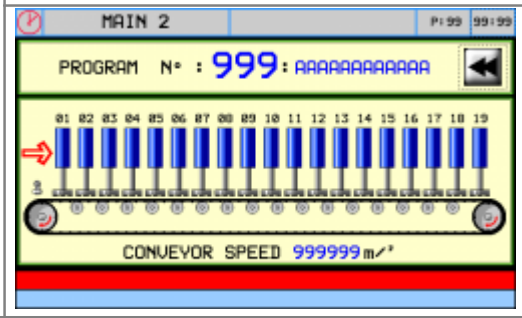
Button	Description	———————-	Top Bar Symbol	Description
	Confirm Popup entry			Manual
	Popup Select			Alarm
	Previous screen & Next screen			Automatic
	Scroll list			Function mode
	Reserved Area			Not initialized
	Quit without saving			Setup Locked/Unlocked
	Confirm setting			Calibration
	Green settings can be changed			
- - - - - - - - - - - -	- - - - - - - - - - - - - - - - - - - -	- - - - - - - - - - - - - - - - - -	- - - - - - - - - - - - -	- - - - - - - - - - - - - - - - - - - -

2.2 MAIN SCREEN





Right IN



Left IN

Top Bar (grey)
- Machine State
- Page name
- Page number
- Time

Bottom Bars
- Alarms (red)
- Warnings (light blue)

3. Startup

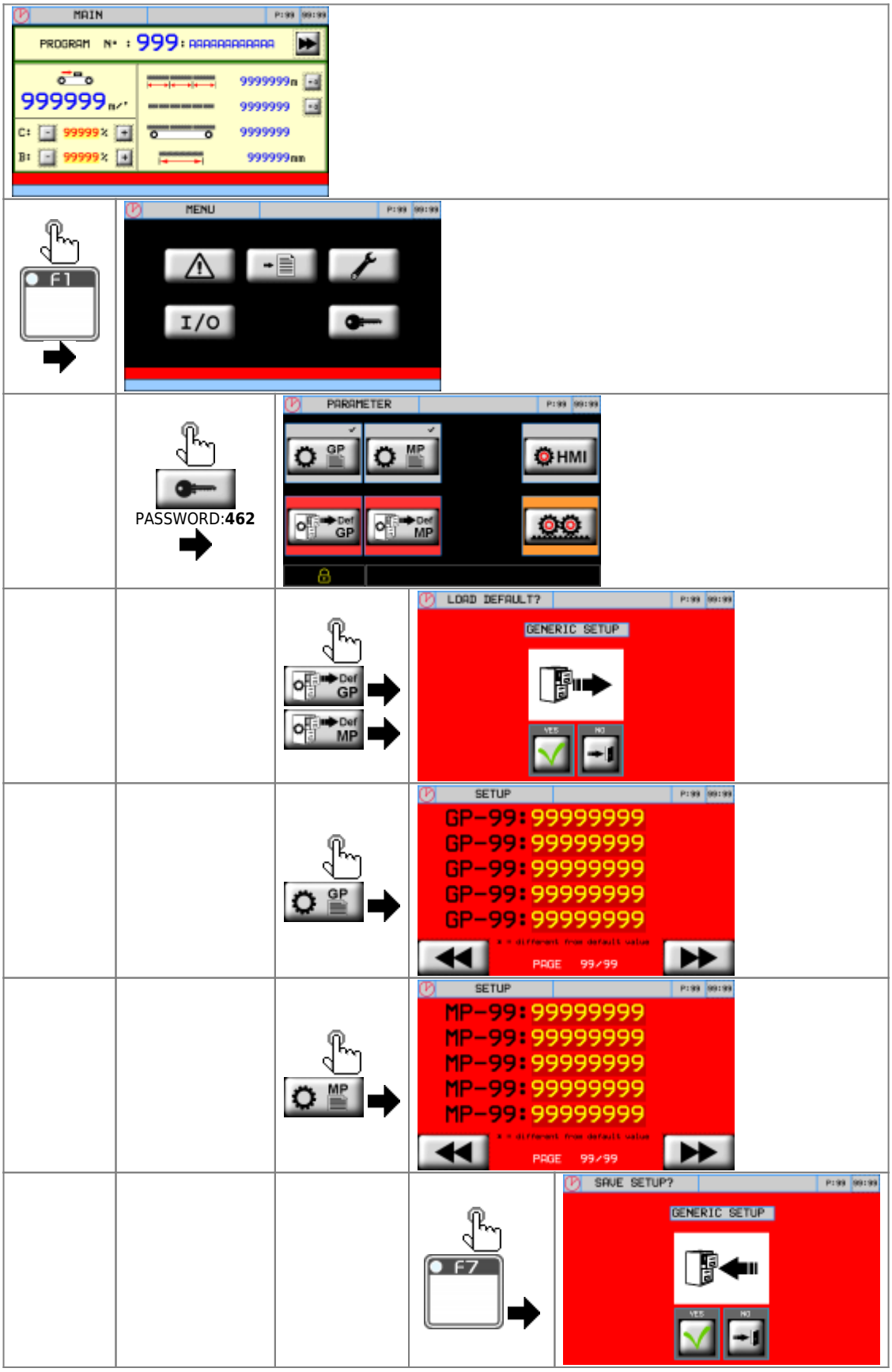
Important

hardware, wiring, general info, system info: Hardware manual

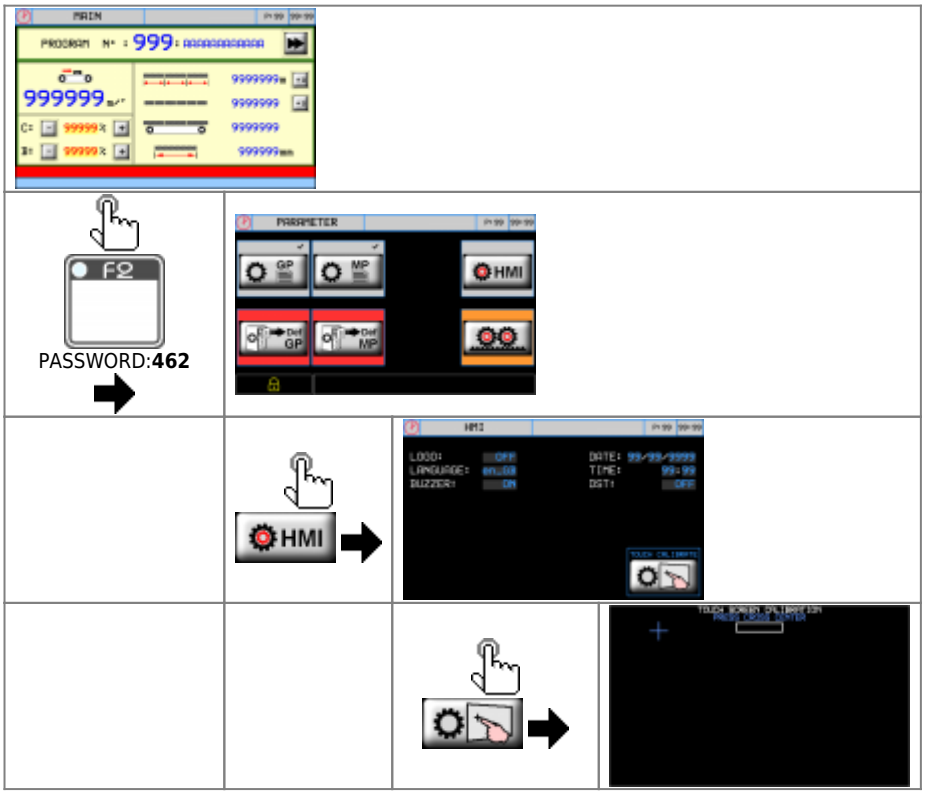
★Per una corretta messa in funzione della macchina, si raccomanda di seguire l'ordine delle attività di seguito descritte e illustrate

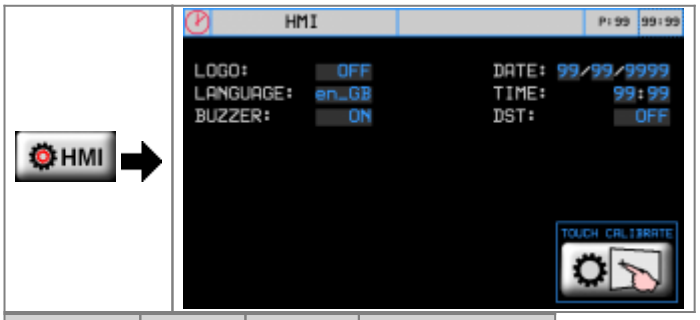
1. Control the application software code in the **Start screen**
2. Controllare la funzionalità del Touch in **HMI Setup**
3. Load the **Default Parameters**
4. Control the **General Parameters - GP** and **Machine Parameters - MP**
5. Check the **wiring** in **Diagnostic** (see **Typical Wiring Diagram**)
6. Check the **Beam direction** forward/backward in the Manual screen
7. Go to **Calibration**
    1. Check the count direction and calibrate the Belt resolution in **Belt Resolution**
    2. Calibrate the **Maximum Belt Speed Calibration**
    3. Calibrate the **Slab IN limit switch offset**
    4. Calibrate the **Head Calibration**
        1. Work diameter
        2. Set the **head distances from the slab IN limit switches**
        3. Set the **Dynamic head Up/Down correction** to the Belt speed
    8. Carry out the **Backup Procedure**
    9. Carry out the **Archiving Procedure**

1. **4. Setup**

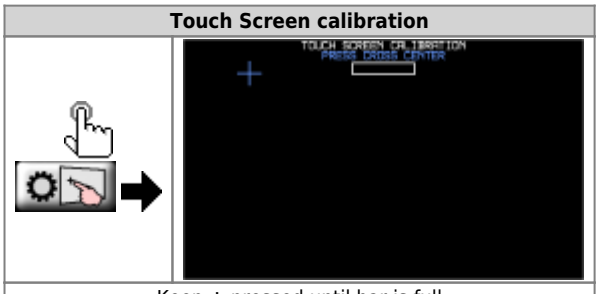

MAIN
PROGRAM N° : 999: AAAAAAAAAA
999999 m/'
9999999 m
9999999
9999999
999999 mm
C: 99999 %
B: 99999 %
F1
MENU
I/O
PASSWORD:462
PARAMETER
GP
MP
HMI
Def GP
Def MP
LOAD DEFAULT?
GENERIC SETUP
YES
NO
SETUP
GP-99: 99999999
PAGE 99/99
MP-99: 99999999
F7
SAVE SETUP?

1. **4.1 HMI Setup**





Parameter	*Default*	*Range*	*Description*
LOGO	ON	OFF ~ ON	**OFF**: No logo **ON**: logo
LANGUAGE	en_GB	-	**en_GB** : English **it_IT** : Italiano
BUZZER	ON	OFF ~ ON	**OFF**: no buzzer **ON**: buzzer
DATE	-	-	Set the date
TIME	-	-	Set the time
GMT TIME	OFF	OFF ~ ON	**OFF**: no legal time **ON**: legal time

Touch Screen calibration

Keep **+** pressed until bar is full

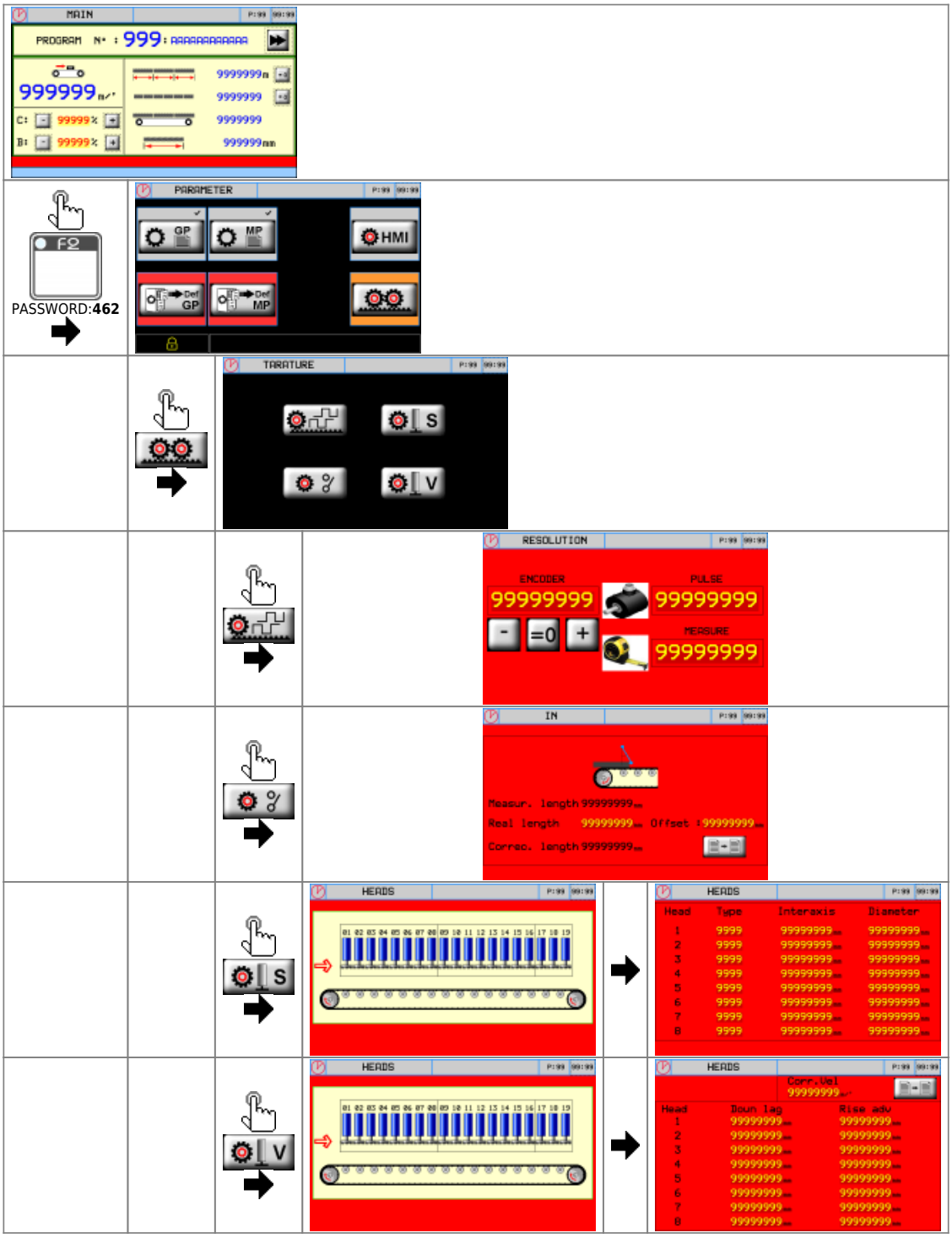
1. **4.2 General Parameters - GP**

Parameter	*U.M.*	*Default*	*Range*	*Description*
GP-01	-	4000	P (Pulse)	**Encoder pulse** reading x 4, corresponding to length in **Measure** .
GP-02	-	400.0	M (Measure)	**Length** corresponding to encoder pulses (**Pulse**) - P/M is the resolution. It must be 0.000935 ~ 1.000000. - Pulse ane Measure are set by the procedure Axis Resolution.
GP-03	-	1	0 ~ 3	**Decimal point** for Belt **speed** **0**=xxxx, **1**=xxx.x, **2**=xx.xx, **3**=x.xxx
GP-04	-	0	0 ~ 1	**Decimal point** for Belt **misura** **0**: xxxx, **1**: xxx.x
GP-05	-	1	0 ~ 1	**Heads Position** at belt speed below the minimum (GP-06) **0** = heads **remain DOWN** . **1** = heads **go to UP** .
GP-06	-	0.1	0 ~ 999999	**Minimum Belt speed**
GP-07	-	0.5	0 ~ 999999	**Speed Delta**, when above the filter is applied (GP-08).
GP-08	msec	50	0 ~ 9999	**Filter** on Belt speed
GP-09	-	0	0 ~ 5	**Sampling Time** of the frequency meter (used to determine the belt speed) **0** = 240 ms, **1** = 480 ms, **2** = 24 ms, **3** = 120 ms, **4** = 960 ms, **5** = 1920 ms.
GP-10	-	0	0 ~ 1	**0** = **Save** slabs when machine OFF **1** = **Do not save** slabs when machine OFF
GP-11	-	0	0 ~ 1	**Slab IN** (input I09) below **minimum speed** . **0** = YES **1** = NO
GP-12	mm	10.0	0 ~ 9999	**Distance**, if below two adjacent slabs are **worked in continuous** The slab counter still counts 2 slabs
GP-13	msec	1000	0 ~ 9999	**t1 time** for motor start output
GP-14	msec	1000	0 ~ 9999	**t2 time** between one motor start and another
GP-15	msec	1000	0 ~ 9999	**t3 time** between the last motor start and O24 output for end of motor start sequence
GP-16	-	0	0 ~ 1	**Abrasive Change Position** **0** = on backward LS **1** = on forward LS
GP-17	-	0	0 ~ 1	**Enclosures** contact logic **0** = NC **1** = NO

1. **4.3 Machine Parameters - MP**

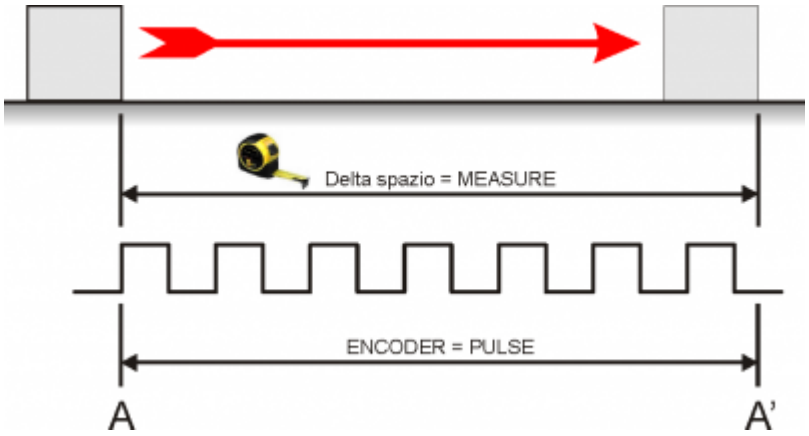
Parameter	*U.M.*	*Default*	*Range*	*Description*
MP-01	-	1	1 ~ 19	Number of heads
MP-02	mm	0	0 ~ 999999	Machine length Distance between the slab IN limit switch and end of the machine
MP-03	-	0	0 ~ 4	Belt **Command/Control** **0** - External Command/Control - speed reading **1** - **Command** - speed reading - analog out **2** - **Command** - speed reading - analog out (set by potentiometer). **3**: - **Command & Control** by encoder feedback - speed reading - analog out - Start/Stop from controller **4**: - **Command & Control** by encoder feedback - speed reading - analog out (set by potentiometer) - Start/Stop from controller
MP-04	-	0	0 ~ 1	**Beam Command** **0** = **External Control**. **1** = **Beam Control** with min & max limit switches and slowdown (Il movimento avviene con almeno un pezzo in macchina).
MP-05	-	0	0 ~ 1	**Motor Start Sequence** . **0** = NO **1** = yes
MP-06	-	-	-	-
MP-07	-	-	-	-
MP-08	m/min	5.0	0 ~ 5.0	**Maximum Belt speed** (AO1 = 10 Volt) (MP-03 > 0)
MP-09	m/min	3.0	0 ~ 5.0	**Max Belt Speed in automatic** (MP-03 > 0)
MP-10	m/min	1.0	0 ~ 5.0	**Belt Jog speed** (MP-03 > 0)
MP-11	-	0	0 ~ 1	**Beam start mode** in automatic (MP-04 = 1). **0** = Start with belt **1** = Start when slab IN
MP-12	s	1.000	0 ~ 999.0	**Tempo di ritardo** tra la Belt start and Beam start (MP-05 = 1)
MP-13	%	5.0	0 ~ 100.0	**% maximum speed** of Beam in automatic
MP-14	%	5.0	0 ~ 100.0	**Slow speed** of Beam in automatic (MP-04 = 1)
MP-15	%	50.0	0 ~ 100.0	**Jog speed** of Beam (MP-04 = 1)
MP-16	s	2.000	0 ~ 999.0	**Beam stop time** at max & min limit switches (MP-04 = 1)
MP-17	-	0	0 ~ 1	**Slab IN Direction** **0** = right **1** = left

1. **4.4 Calibration**



1. **4.4.1 Belt resolution**

Procedure



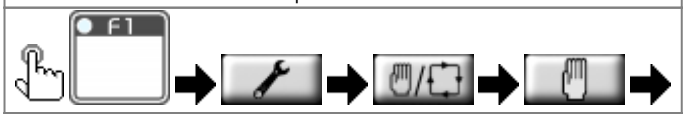
- Press + and check the ENCODER box increases(Analog out +1 Volt)
- Press - and check the ENCODER box decreases (Analog out -1 Volt)
- A - A' = The maximum space
- Take note of the start position (A)
- Zero-set the **ENCODER**: = 0
- Move the axis from A to A'
- Take note of the reading in **ENCODER** box and write it in the **PULSE** box
- Measure the distance from A to A' = **space delta**
- Enter the A - A' **space delta** in the **MEASURE** box

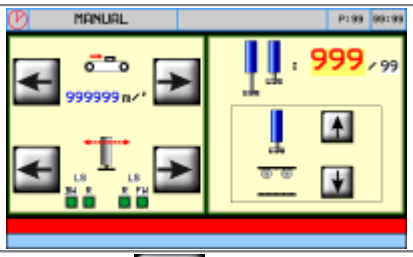
Important:

- **PULSE** must alway be greater than **MEASURE** (the best is “MEASURE x 10 = PULSE”)
- Enter **MEASURE** in the selected **unit measure**. E.G. if a unit measure of 1/10mm is selected and the **space delta** is 133.5mm, enter 1335 in the **MEASURE** box

1. **4.4.2 Maximum Belt Speed calibration**

Set the same speed in MP-08 and MP-10





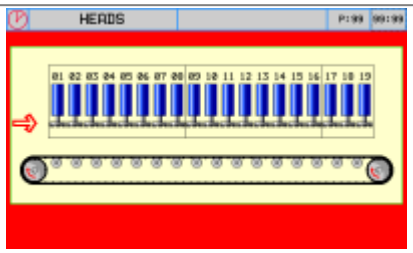
start the belt

Take note of the speed

Set the speed in MP-08

Set MP-09 and MP-10 as required

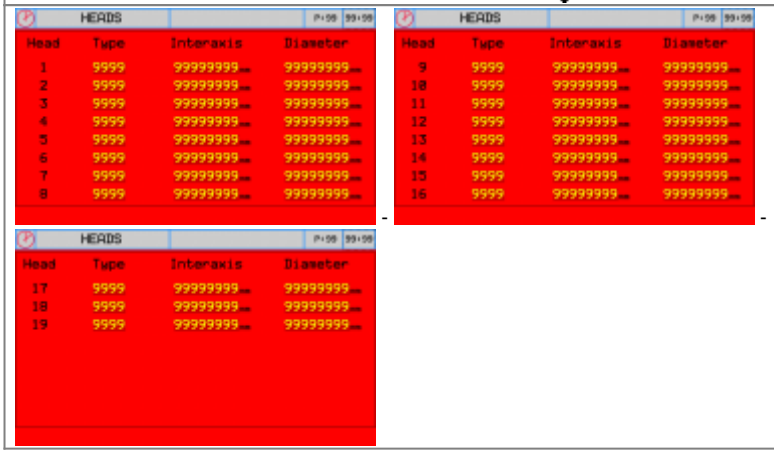
4.4.3 Head Calibration



OR

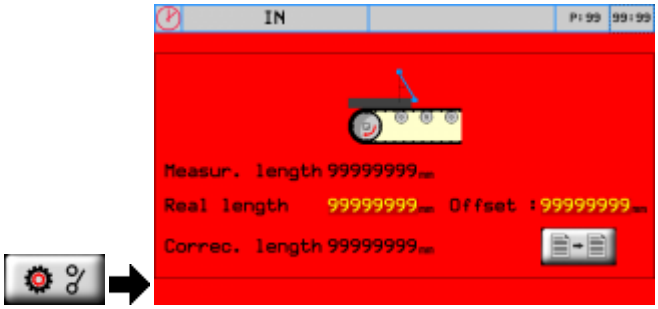
MP-16 = Slab infeed direction

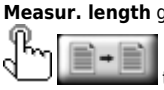
head group box



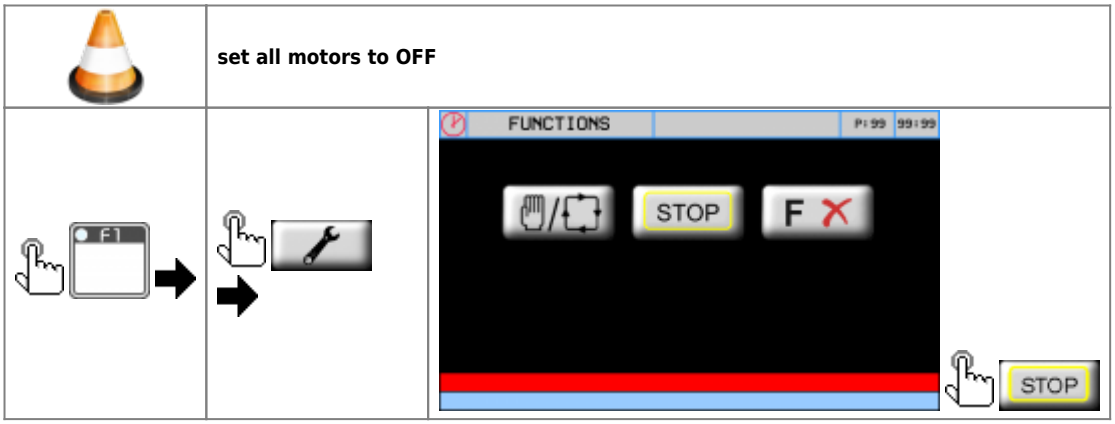
Parameter	*U.M.*	*Default*	*Range*	*Description*
Type	-	-	0 ~ 5	Head function modes **0**: OFF **1**: Polishing **2**: Milling **3**: molatrice **4**: Brush **5**: Air/water jet
Interaxis	mm	-	0 ~ 99999.0	Distance from **slab IN limit switch** to the **head center**
Diameter	mm	-	0 ~ 99999.0	Work diameter

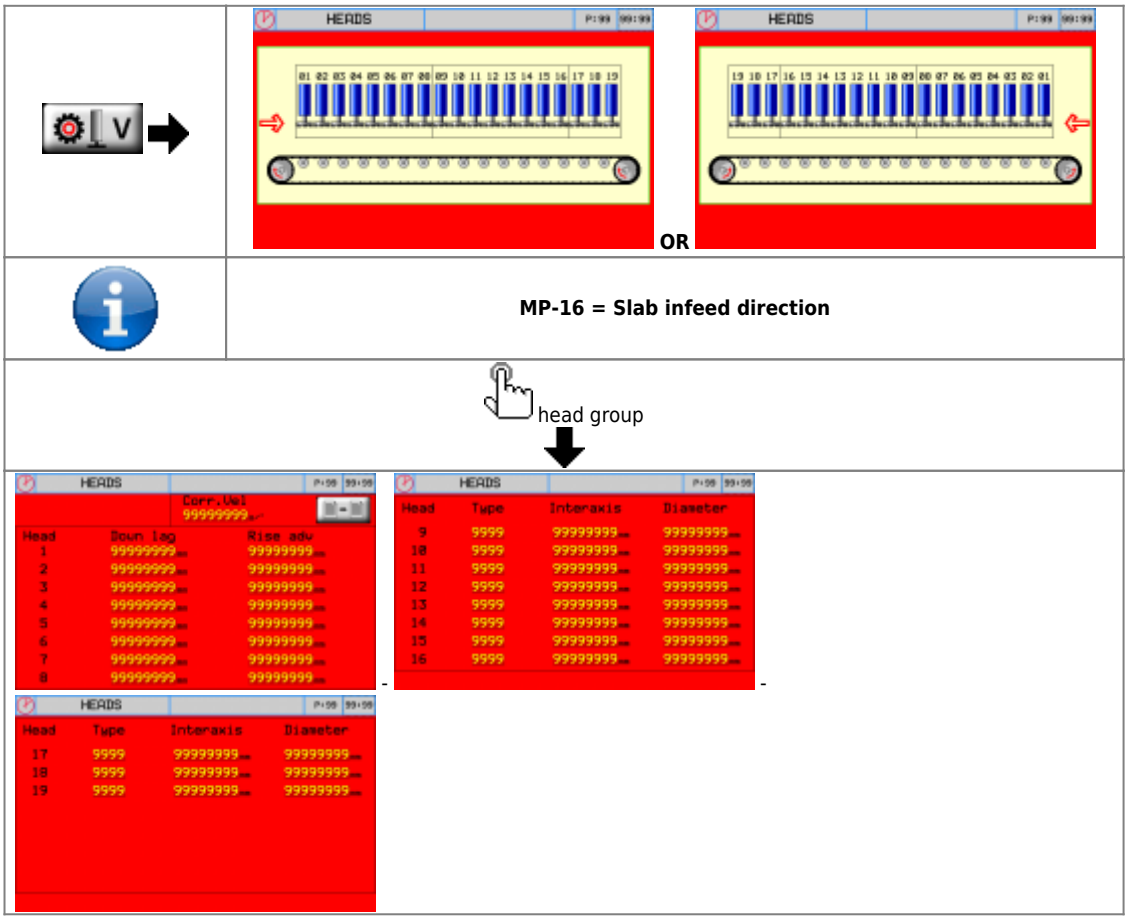
1. **4.4.4 Slab IN limit switch offset**



1. Measure the length of a slab and enter in **Real length**
2. **Start** the belt so the controller reads the slab length by the slab In limit switch
3. **Measur. length** gives the length reading
4.  to set the limit switch offset
5. The offset can also be changed manually
6. Correc. Length shows the new corrected length

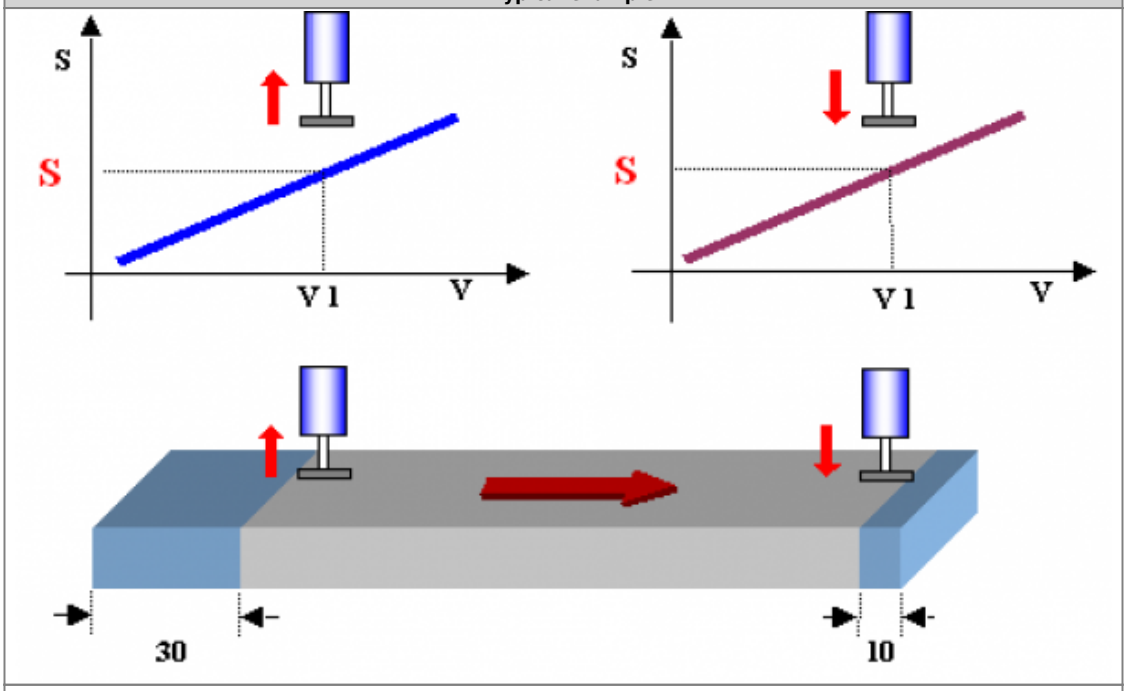
1. **4.4.5 Dynamic head Up/Down correction**





Parameter	*U.M.*	*Default*	*Range*	*Description*
SPEED CORR.	m/min	3.0	0 ~ 5.0	**Reference speed** for Dynamic calibration
Down lag	mm	-	-999.0 ~ 999.0	(+) **Delay distance** for head DOWN on **slab front** .
Rise adv	mm	-	-999.0 ~ 999.0	(+) **Advance distance** for head UP before **slab end** .
	Copy settings to all heads			

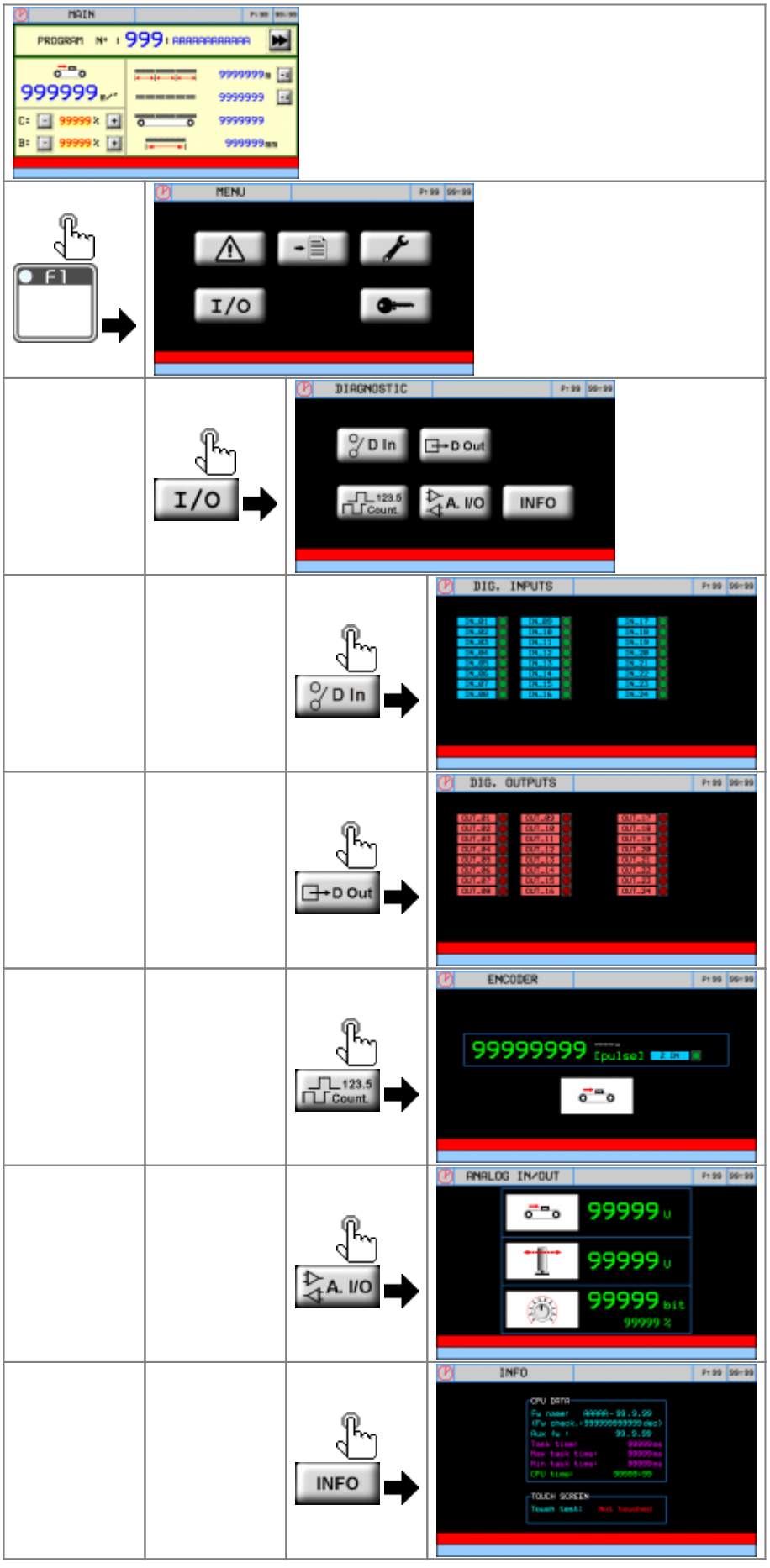
A Typical example



To Polish ALL the slab at V1 = 3 m/min, set **Downlag = 10**, **Rise adv = - 30**

The lags and advances for other speeds are calculated automatically

1. **5. Diagnostic**

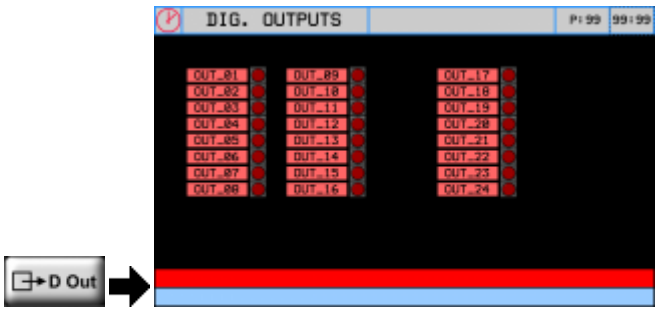


1. **5.1 Digital Input diagnostic**

INPUT	NAME	LOGIC	DESCRIPTION	
I01	Emergency	NC - O	**Stop**	with Alarm message
I02	Not used	-	-	
I03	Start motors	NO - C	**Start** motor sequence	con MP-05 = 1
I04	Power system enabled	NO - C	Machine ready	-
I05	NE	NC - O	In automatic, stop beam and belt /Reset the “motor rotation startup error” message	-
I06	Overload cutouts	NC - O	Chain of overload cutouts	with Alarm message
I07	Enclosures	NC - O	Chain of enclosures	
I08	Air pressure switch	NC - O	No air	
I09	Slab IN	NO / C	**Limit switch** for slab **length acquisition**	
I10	Not Used	-	-	
I11	Not Used	-	-	
I12	Inverter fault	NC - O	Inverter alarm	with Alarm message
I13	Beam Forward LS	NC - O	**Beam forward limit switch** with **fast speed**	con MP-04 = 1
I14	Beam Backward LS	NC - O	**Beam backward limit switch** with **fast speed**	
I15	Beam Forward Slow LS	NO - CC	**Beam forward limit switch** with **slow speed**	
I16	Beam Backward Slow LS	NO - CC	**Beam backward limit switch** with **slow speed**	

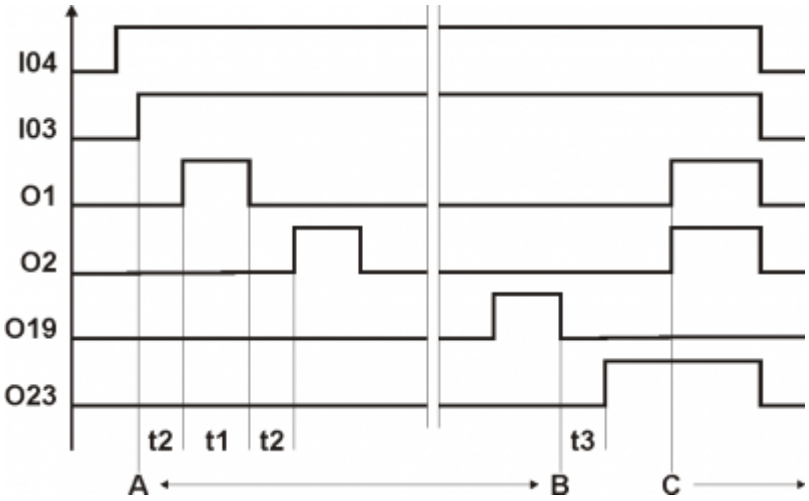
Note
★ NC - O = **N**ormally **C**losed contact, action when the contact **O**pens
★ NO - C = **N**ormally **O**pen contact, action when the contact **C**loses
★ NO - CC = **N**ormally **O**pen contact, action when the contact **C**losed in **C**ontinuous

5.2 Digital Output diagnostic



N°	DESCRIPTION
O1~O19	Head UP/DOWN and motor start commands
O20	Belt direction - **OFF** forward - **ON** backward
O21	Beam direction - **OFF** forward - **ON** backward
O22	**Water valve** output
O23	Trips when **slabs < 30** in machine (upline machine consensus)
O24	**Machine OK** output

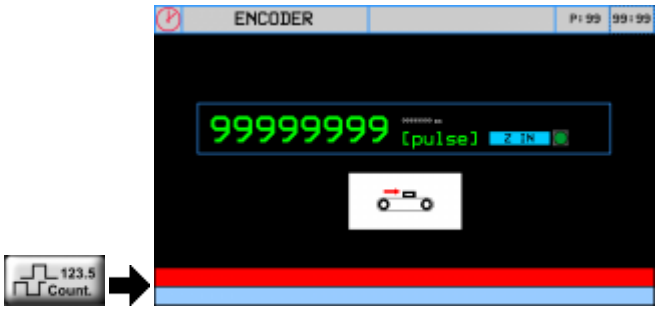
1. **5.3 Operating Diagrams**



- **t1** one motor start time
- **t2** time between one motor start and another
- **t3** at end of motor starts(O19 = OFF), wait **t3 time** for O23 = ON
- **O23 = ON** end of motor starts and OK to start loading slabs upline
- **A - B** start head motors time
- **C** time before machine is ready for work

5.4 Belt encoder count

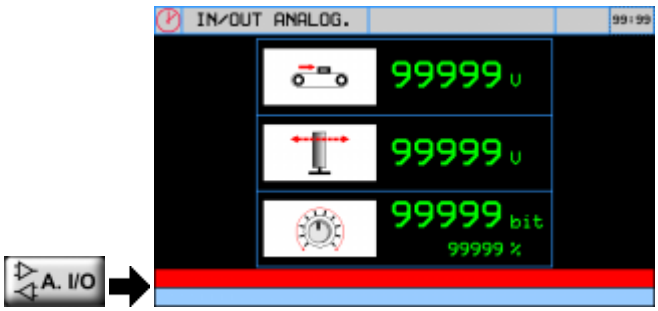
N°	NAME	DESCRIPTION
PHA1/PHB1	Belt encoder signals	- to measure the **slab lengths** and **establish their position** on the belt - measure the **feed speed of the slabs** and calculate the head Up/Down **advances - delays**



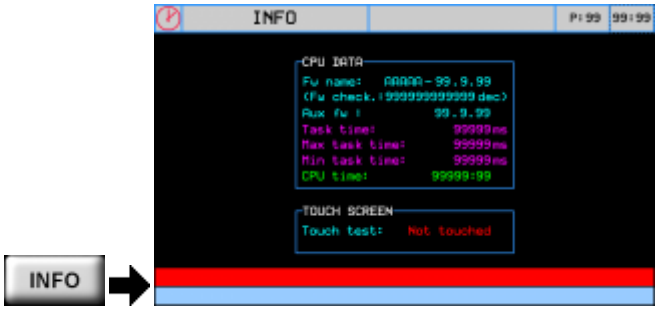
Note:
• **Z_INP** led signals the Z pulse input state (**not used** in this application).
• Pulse : Encoder pulses x 4

5.5 Analog Inputs and Outputs

N°	NAME	DESCRIPTION	
AI1	Analog input, belt speed variation (analog out AO1).	Potentiometer input. Reading in bit and percentage	
AO1	Out 0~10 Volt	Inverter command	Belt
AO2			Beam

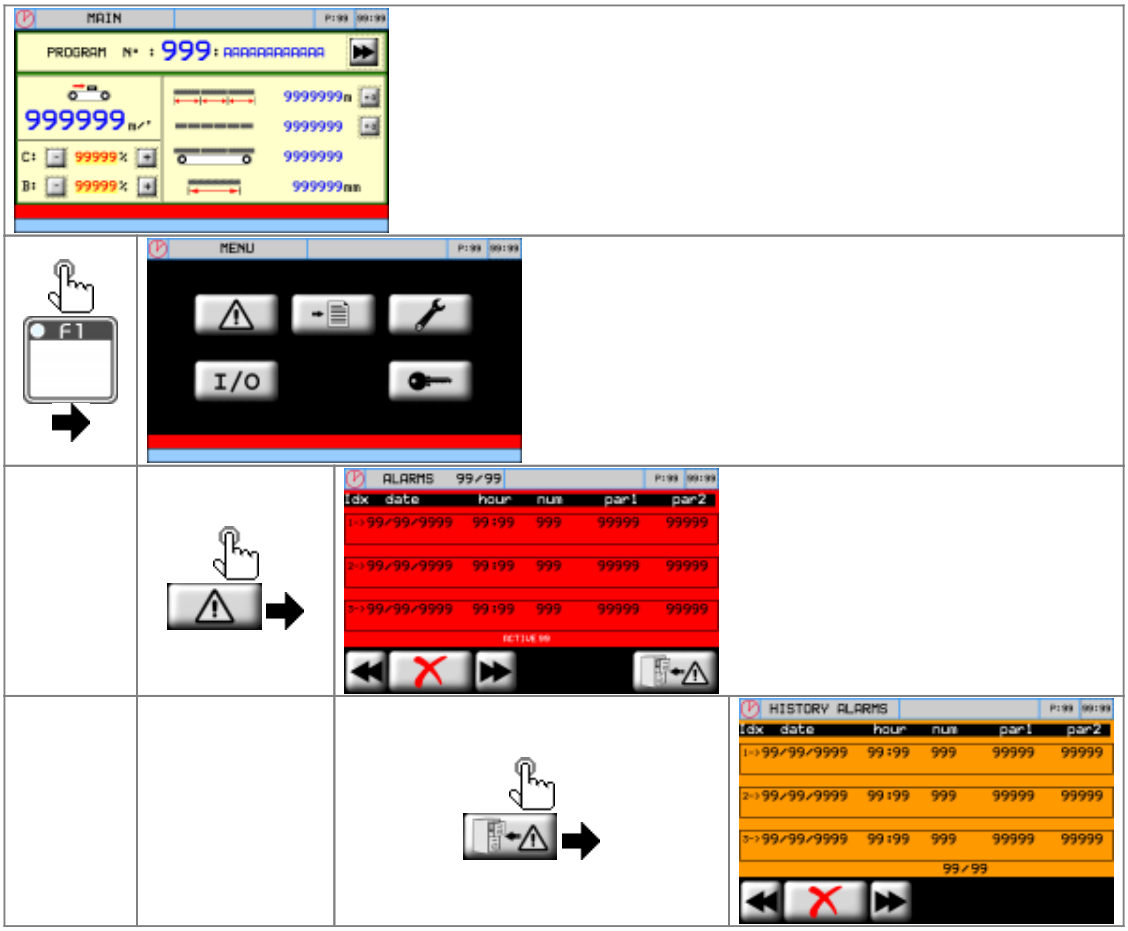


5.6 System Info

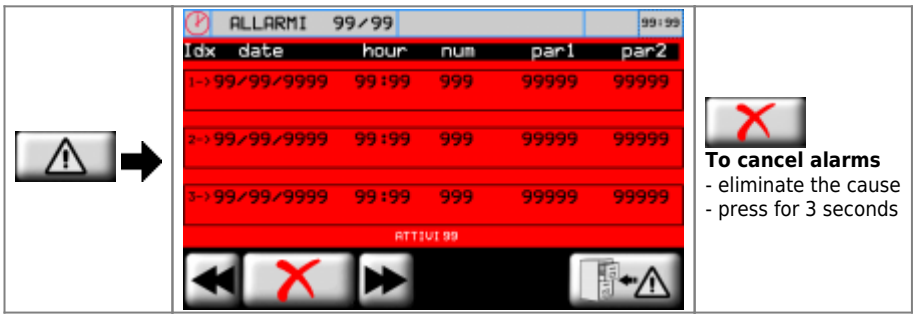


Fw name	firmware and checksum names
Aux fw	I/O module firmware (not used in this application
Task time	CPU cycle time: **Minimum, Medium, Maximum**
CPU time	CPU run time (hh:mm)
Touch screen	Test touch

1. ## 6. Alarms



6.1 Alarm list



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Message	Cause	Input
Emergency pressed	Check the emergency button and line	I01
Inverter fault	Control the inverter	I12
Belt encoder fault	Control the belt encoder (Acive only with MP-03 > 2).	
Overload cutouts	Check the overload cutouts	I06
Enclosures	Check the enclosures	I07
No air	Check the air pressure switch	I08
	the **Belt encoder fault** alarm trips automatically if the belt moves less 2 u.m. in 5 seconds (less than 60 mm/min)	

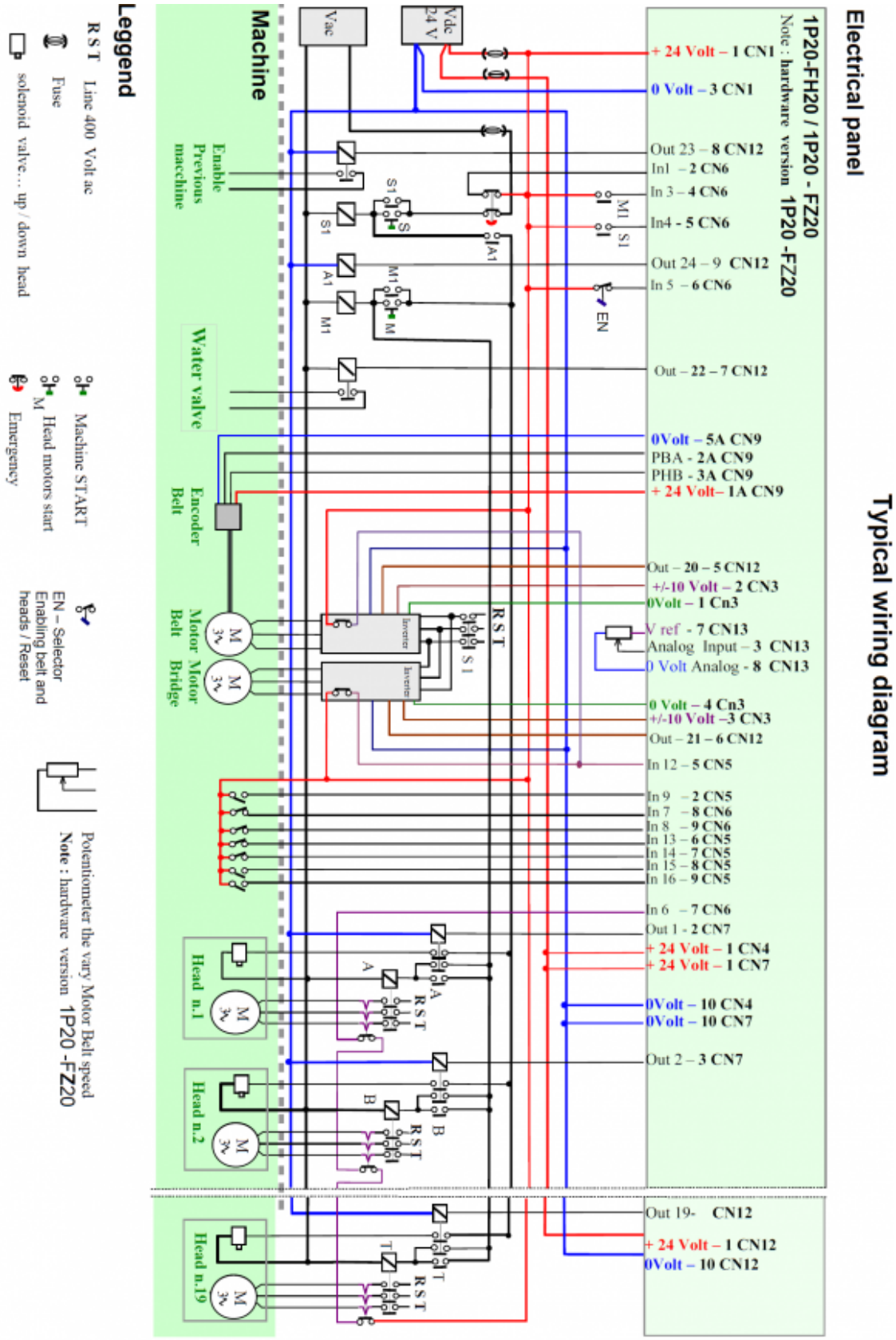
1. **6.2 Alarm history**

<table>
<tr>
<td> </td>
<td>
</td>
<td>
To cancel alarms
- eliminate the cause
- press for 3 seconds</td>
</tr>
<tr>
<td> </td>
<td colspan="2">Maximum 60 alarms</td>
</tr>
</table>

7. Warnings

Message	Description
Too many slabs in the machine	There are more than 30 slabs in the machine
Waiting for power system...	Waiting for the power system to startup (MP-08 enabled)(I04 = ON)
Going to change abrasive position...	The beam has been commanded to move to change abrasive
Power system disabled	Power system disabled (I04 = OFF).
Caution Motors off	Belt start attempted with motors off

1. **8. Typical wiring diagram**



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