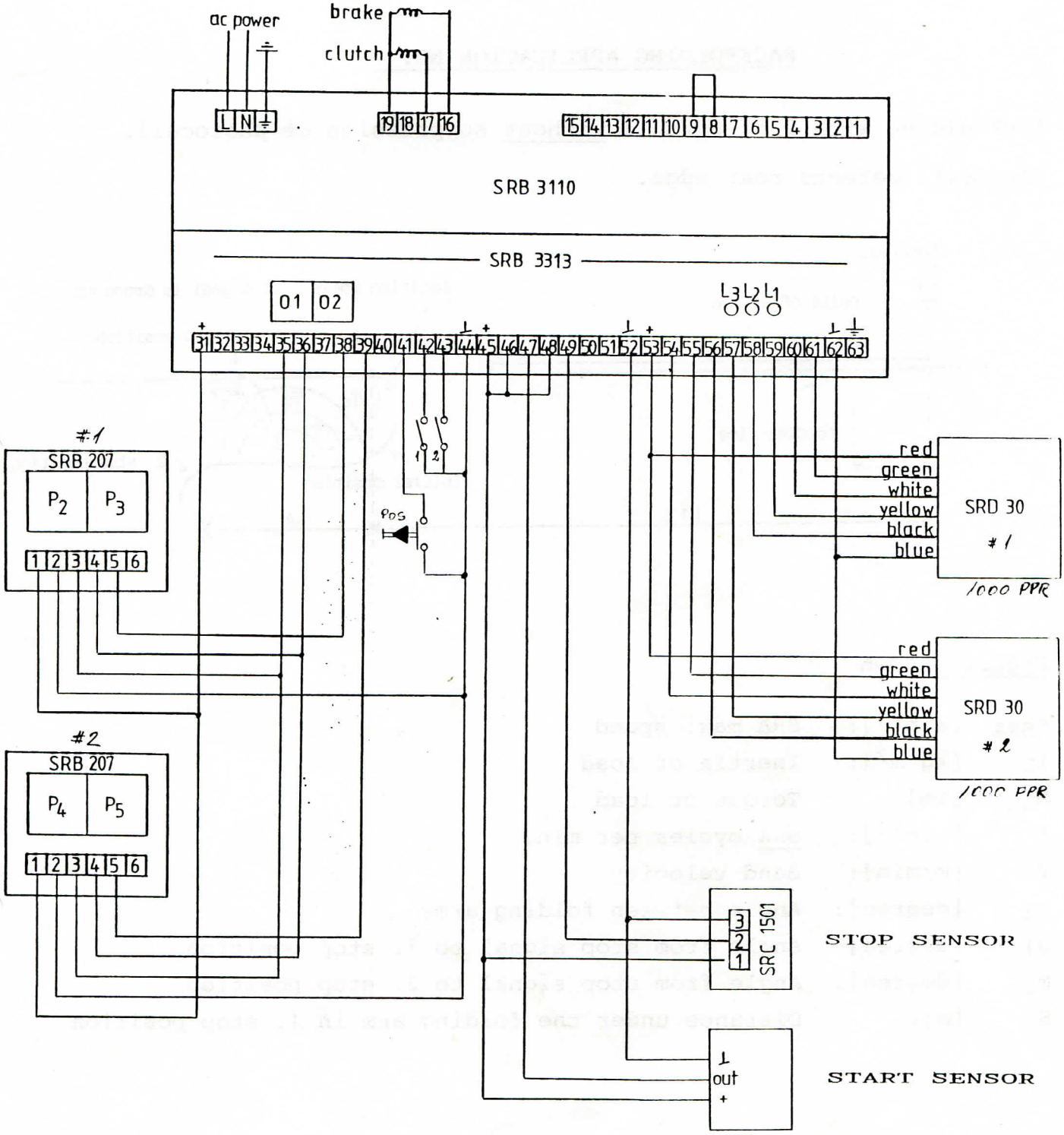
1988MAR10.

BÄCKFOLDING APPLICATION NO. 2



Programming of SRB 3110:

MK1: 1-2 MK4: 1-2
MK2: 1-2 MK5: 1-2
MK3: 2-3

Programming of I/O card 080B6162:

MK1: Activation edge on stop signal
1: Stop when optocoupler is switched on.
2: Stop when optocoupler is switched off.

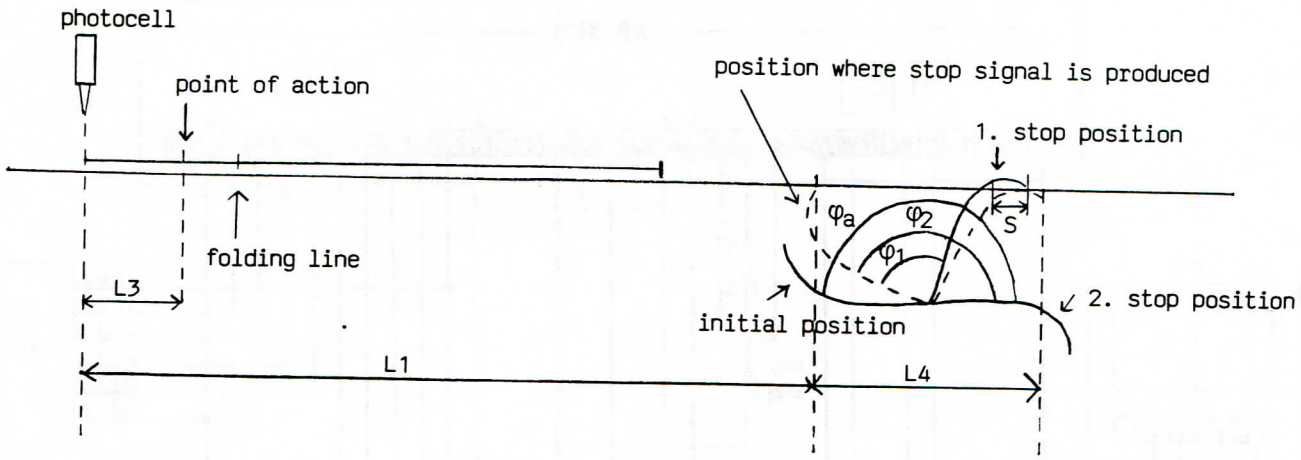
MK2: Activation edge on start signal
1: Start when optocoupler is switched on.
2: Start when optocoupler is switched off.

8803/0 E1

BACKFOLDING APPLICATION NO. 2

Backfolding with 2 steps/unit without suppression of photocell.

Photocell detects rear edge.



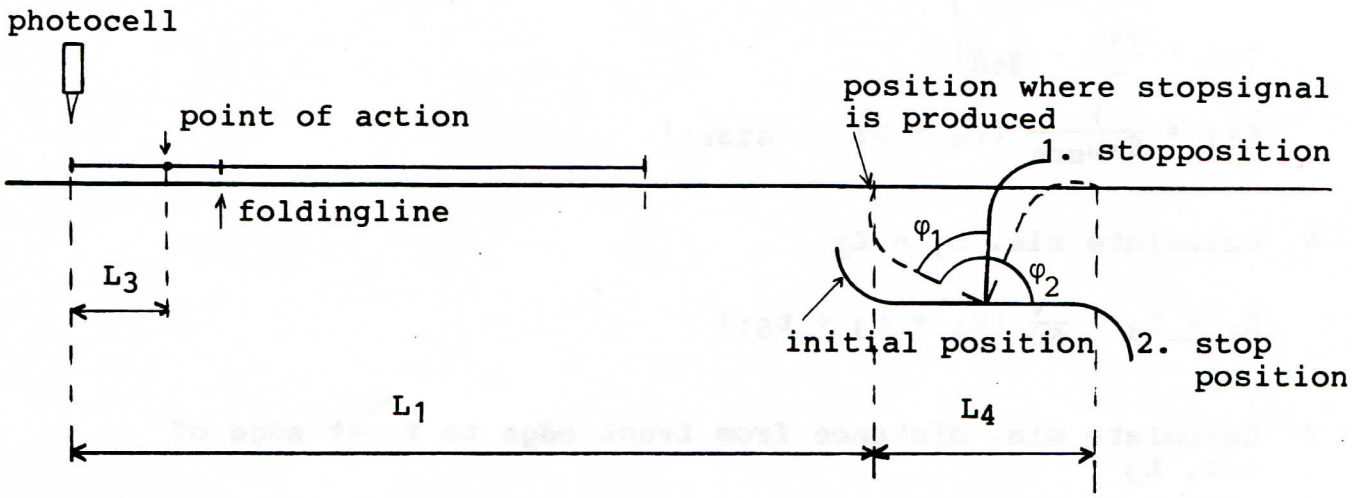
Figures known

n_{SRA}	[min^{-1}]:	SRA max. speed
I_L	[kg m^2]:	Inertia of load
M_L	[Nm]:	Torque of load
A	[min^{-1}]:	SRA cycles per min.
V	[m/min]:	Band velocity
φ_a	[degree]:	Angle between folding arms
φ_1	[degree]:	Angle from stop signal to 1. stop position
φ_2	[degree]:	Angle from stop signal to 2. stop position
S	[m]:	Distance under the folding arm in 1. stop position

BACKFOLDING APPLICATION NO. 2

Backfolding with 2 steps/box <u>without</u> supression of photocell.

Photocell detects rear edge.



<u>SRB 207 preselectors</u>

$P_2 = \varphi_1$: 0-999°

$P_3 = L_1 - L_3$: 0-999 mm

P_2	P_3	#1

$P_4 = \varphi_2$: 0-999°

$P_5 = L_4$: 0-999 mm

P_4	P_5	#2

<u>Switch on 080B6162 I/O-Card</u>

O_1 : not used

O_2 : position 2

<u>LED Indication</u>

LED 1: $L_1 - L_3$ too short

LED 2: φ_1 too small

LED 3: $\varphi_1 > \varphi_2$ or $\varphi_2 - \varphi_1$ too small