

META-Automation

O-Frame Application Carton 400 - 1000 gsm

Paper Machine Manufacturing for Carton.

The Application consists of the Measurement of Basis Weight and the Moisture in scanning Mode by dividing the web in 64 Data Segments (Cross-Direction) and Profile Calculation . The Control of Basis Weight occurs over Thickstock-Flow in Set Point Control (SPC)-Mode and the Control of Moisture via Steam-Pressure with Steam-Step-Down Control in Case of Web-Break (or Emergency Stop).

Technical Data

Basis Weight Measuring Head : Kr-85, 200 mCi, WMR-9

Moisture Measuring Head : Microwave, Transmission-Mode, MMW-9

Machine Speed : up to 400 m/min

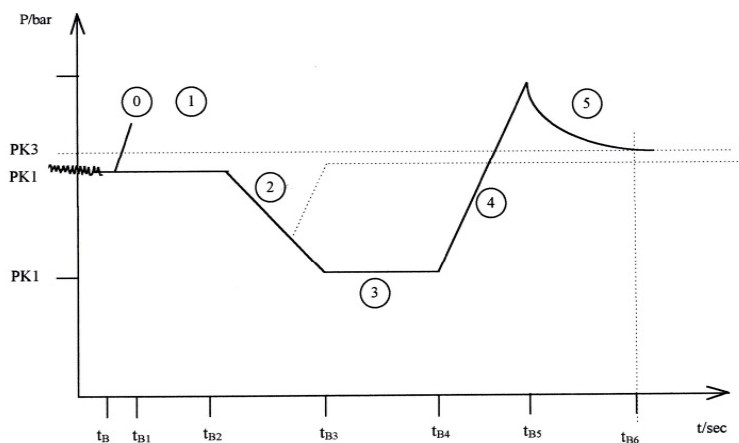
Ambient Conditions

Harsh industrial Enviroment, dusty, Ambient Temperature up to 50 oC

Configuration

Scanning Frame : O-Frame Constuction, automatic scanning System between Photocells.

Main Enclosure (IP54), industrial PC, Printer, Control Valve, external PID-Controller, Communication ProfiBus-DP



- t_B - web break time, control off
- t_{B1} - start of waiting time
- t_{B2} - start of steam step down
- t_{B3} - time of constant value
- t_{B4} - Web O.K. - status
- t_{B5} - Start of exponential step down
- t_{B6} - Control on

STEAM STEP DOWN CONTROL