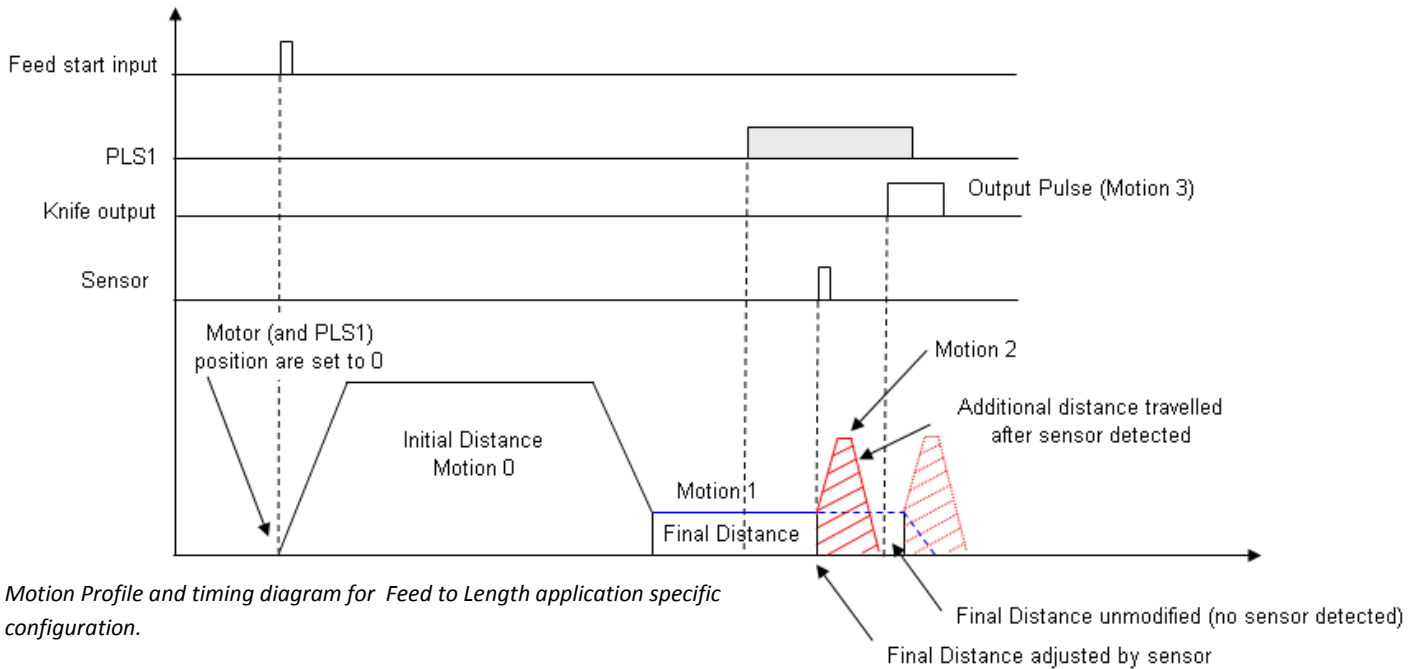


Feed to Length—Indexer Configuration



Description of Application

This pre-engineered XD-Indexer configuration is designed to implement a Feed (Cut) to Length application.

Feed to length applications typically feed material using a nip-roll at a high initial speed for a defined initial distance. The rolls are slowed down to a final speed and continue feeding at the lower speed for a set final distance or until an external high-speed sensor input becomes true. Optionally, an additional fixed distance is moved after a sensor signal is detected.

ORMEC Indexer Implementation

The digital I/O functions described can be used on any Indexer input or output.

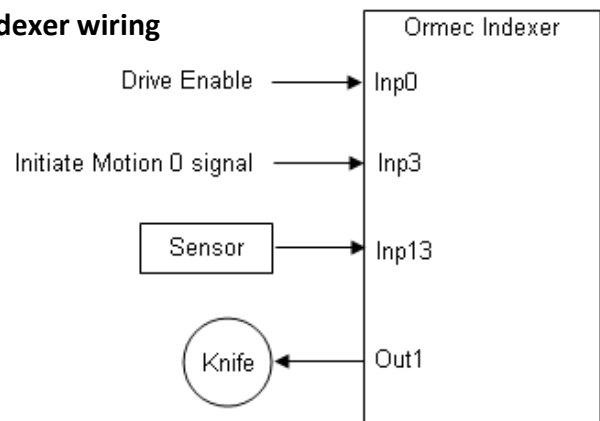
Input 3 is triggered by an external signal (PLC, pushbutton, contact, etc.) This input initiates the initial distance motion configured as 'Initiate Motion 0'.

A sensor is wired to Indexer Input 10 which is configured as 'Sync Condition 1' function. The knife solenoid is wired to Output 1. A sensor signal is gated with the PLS1 output such that it is read only with a position range of 'PLS1 First On' to 'PLS1 Last On'. The motor position is set to 0 at the start of Motion 0. This is done by attaching a second function of 'Set Position to 0' to Input 3 which is configured as 'Initiate Motion 0' (each input allows two

functions). The 'PLS1 First On' position is set to the position from which the sensor signal needs to be watched. The 'PLS1 Last On' position is set to the total distance of Motion 0 and unmodified Motion 1.

*note: To create a Feed to Length configuration for an Indexer electronically geared to a master encoder use the GearRelativeInMasterDistance motion type.

Indexer wiring



Download Configurations

The configurations for this application may be downloaded from the XD-Series Software area of the ORMEC website. For addition information, consult ORMEC sales support at (585) 385-3520 or email sales@ormec.com