

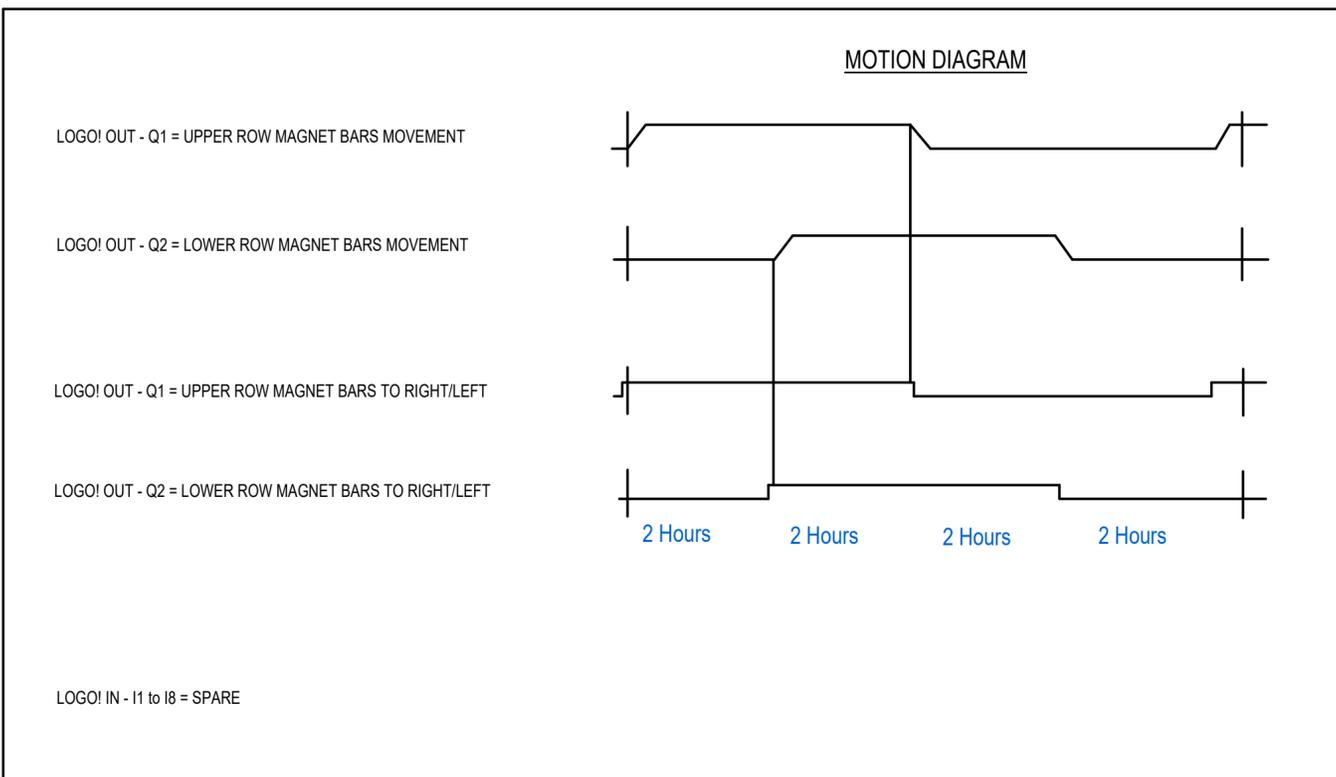
REV	DATE	BY	DESCRIPTION
-	14-5-2013	AvD	NEW REVISION VAULT, NOTHING CHANGED, OLD REV WAS D
A	16-3-2017	AvD	EISE000005 WAS EISD043005
B	20-10-2023	CR	TEXT IS NOW READABLE

**PROCES DEFINITION:**

IN PROCES situation:  
 - Magnet bars ALWAYS remain IN the product channel!!!

Cleaning cycle (iron disposal):

1. LOGO! program creates cleaning action signal every 2 hours, or by start pulse if i6 = high
2. Magnet bar tubes move to LEFT or RIGHT after (Fe) cleaning signal, also taking the separated Fe parts with them to the side channels; (bars move over the magnet bars, that remain in the product channel),
3. After 4 hours tubes move back to other side again, now dropping the iron parts there, or by start pulse if i6 = high
4. This action repeats itself every 4 hours, or by start pulse (parameters 2 and 4 hours can be adapted by editing the time paramater via the LOGO! display "edit parameters" mode



This program is written for SECC continuous cleaning cleanflows. The program generates a time controlled cycle for alternatively cleaning (Fe disposal) of the upper and lower magnet bar row.

**Cycle:**  
 2 hours after start: cleaning upper layer of magnet bars,  
 2 hours later followed by the lower layer of magnet bars,  
 2 hours later the upper layer, etc.

**LOGO! INPUT SIGNALS:**  
 The program expects the cleanflow to be executed without sensors

- i1 = SPARE
- i2 = SPARE
- i3 = SPARE
- i4 = SPARE
- i5 = SPARE
- i6 = SPARE

The magnet bar movement is time controlled by software.

**LOGO! OUTPUT SIGNALS:**  
 With the help of a time control the program is able to create a sequence movement:

- Q1 high = Magnet bar tubes of UPPER ROW move to drop Fe parts in the RIGHT side chanel
- Q1 low = Magnet bar tubes of UPPER ROW move to drop Fe parts in the LEFT side chanel
- Q2 high = Magnet bar tubes of LOWER ROW move to drop Fe parts in the RIGHT side chanel
- Q2 low = Magnet bar tubes of LOWER ROW move to drop Fe parts in the LEFT side chanel
- Q3 = SPARE
- Q4 = SPARE

**LOGO! version 0BA3 (yellow/red eprom):**  
 FILE LOCATION:  
 F:\groups\Engineering\Logo-programma's\SECC\Programma's V3\_1 voor eprom geel en rood - tot 5-04\  
 FILE:  
 M24967B SECC 1 layer each 2 hours (standard)-V3\_1.lsc

**LOGO! version 0BA4 (brown eprom):**  
 FILE LOCATION:  
 F:\groups\Engineering\Logo-programma's\SECC\Programma's V3\_1 voor eprom geel en rood - tot 5-04\  
 FILE:  
 M24967B SECC 1 layer each 2 hours (standard)-V4\_0.lsc



1	1	EISE000005	MicroSDHC Card Class4	
ITEM	QTY	PART NUMBER	DESCRIPTION	Dimensions
RAW MAT.	1			
Quantity	Material Number	Material Description		Length (mm) Width (mm)
Sheet: <b>A2</b>	Extra info:	General tolerance: <b>ISO 2768 - mK</b>		
Drawn: <b>AvD</b>	Weight (kg): <b>0,000</b>	Drawn according: <b>ISO286; ISO1101; ISO2553</b>		
Date: <b>6-6-2000</b>	Status: <b>Standard</b>		Customer reference number:	
Spare part: <b>False</b>	Source:	Document number: <b>M24967</b>		Doc.Rev: <b>B</b>
Quick search: <b>SECC LOGO</b>	Description: <b>SECC-000-LOGO PROGRAM 2 HOURS</b>		Part number: <b>M24967</b>	Rev: <b>B</b>