

## CHANDAN SENSOR CONTROLS

### PLC BASED AUTO CUT TO LENGTH PANEL SYSTEM.

MARCH 2014

The all new Auto Cut to Length System based on Encoder and High Speed Timers cuts to any desired length with accuracy of 4"- 6" inch variation depending Pushers Pullers Rollers are in good condition and not much variation in Temperature of the finished product.



#### Operating Instructions

##### Panel Consists

##### External Control & Internal Control

##### External Control

HMI

Toggle Switch

Lamps

##### Internal Controls

PLC

SSR

RELAYS

MCB

Connectors

# HMI (Human Machine Interface)

# OMRON

Programmable Terminal

# NP Series



## Easy Setup Compact NP Series

# NP



realizing

## Operating Screens

### Screen 1

L1	#####
L2	#####
L3	#####
L4	#####
L5	#####
NEXT	123456

This Screen is for Entering Encoder Value

L1 - L5

### Screen 2

L6	#####
L7	#####
L8	#####
L9	#####
L10	#####
NEXT	123456

This Screen is for Entering Encoder Value

L6 - L10

Screen 3

T1	#####	12345
T2	#####	12345
T3	#####	12345
T4	#####	12345
T5	#####	12345
BACK	MAIN	NEXT

**This Screen is for entering Timer Value**

**T1 - T5**

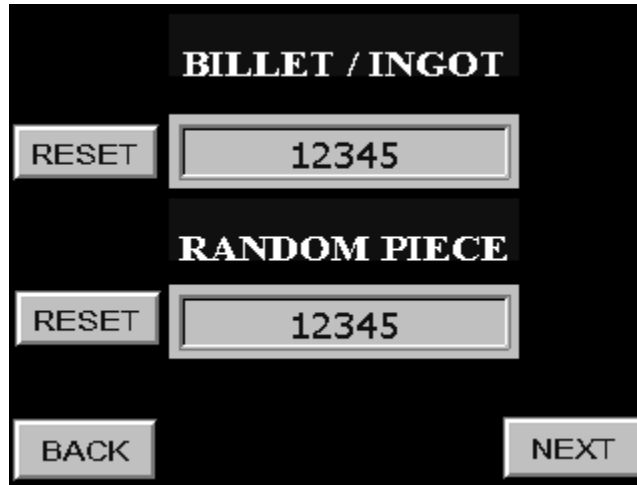
Screen 4

T6	#####	12345
T7	#####	12345
T8	#####	12345
T9	#####	12345
T10	#####	12345
BACK	MAIN	NEXT

**This Screen is for entering Timer Value**

**T6 - T10**

Screen 5



This Screen displays Production for "Billet/ Ingot"

And

"Finished Pieces" in Cooling Bed.

Screen 6

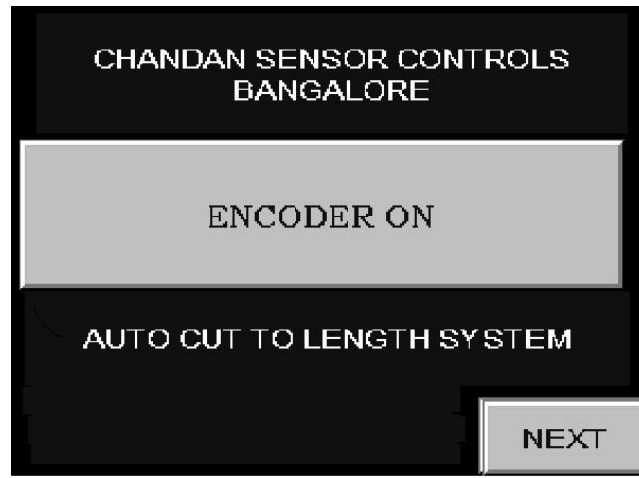


This Screen Displays the Encoder RPM Speed

And

"Shifter Delay Time" for Last Piece to Enter and Shift to Home Position.

Screen 7



This Screen enables the "Encoder Mode" if turned ON

Else it goes to

"Timer Mode" if turned OFF.

