BOLDER

GraviSys-g/m-R

Retrofit of weight-per-meter control for blown film lines

Product information

Features

Individual system components

- Weigh hopper with loss in weight controller
- Siemens PLC with 7" touch screen , TFT colour
- Line speed measurement with rotary encoder

Control of extruder and take-off unit

- Output : 0-10Vdc, up&down, PROFINET
- Optional: Output to motorized potentiometer
- Ramp function for extruder or synchronous ramp function for both drives

Production control - MES (**M**anufacturing **E**xecution **S**ystem)

- Order management
- Bar graph of work in progress
- Reporting: product length, material consumption, production time
- Trend charts of process values
- Quality evaluation with characteristic values
- Network link to host system

Scope

Closed-loop weight-per-meter control has been used in blown film lines for many years. Many existing systems are getting on in years and are no longer state-of-the-art. Resultant electronics malfunctions, control problems and substandard performance cause frequent headaches for production operations.
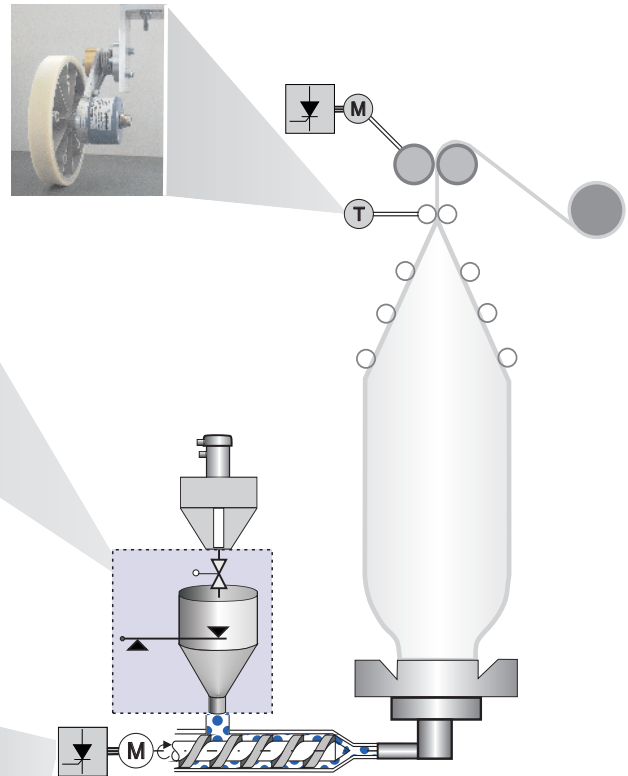
There is a solution available. We can refurbish single components or retrofit your entire system if required by the problems at hand. The core elements of our systems are the Siemens PLC S7-1200 and the GraviProfi 2408. Our systems are compatible with all weigh hopper makes equipped with strain-gauge load cells. For systems requiring new weigh hoppers, we offer our BTW weigh hoppers with outstanding overload protection.

Our PLC systems and HMI panels can be personalized in accordance with users' specific requirements. Host PC's with Siemens WinCC visualization software can be used to provide up-to-the-minute data overviews for all production lines, a highly valuable tool for production managers.

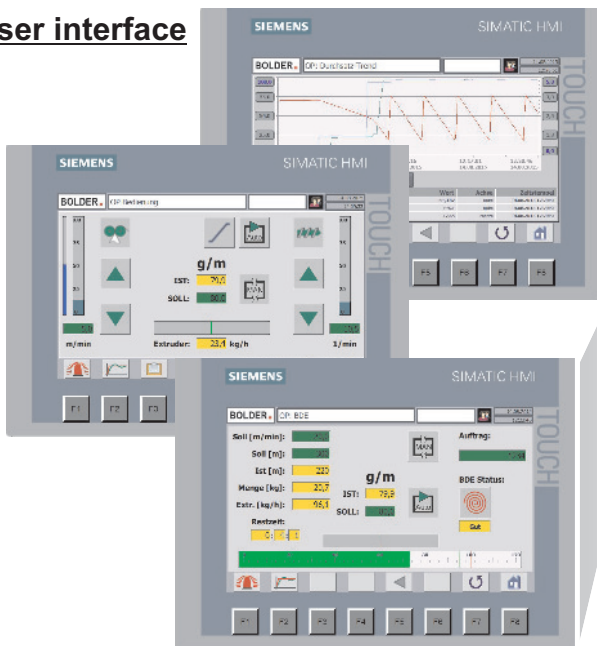## Weigh hopper and throughput controller

Line speed measurement

Weigh hopper / features

- Base-mounted scale
- High overload protection
- Rugged design
- GP2408 for monitoring, control and diagnostics
- Calibration done directly at weigh hopper

User interface

Process control / features

- User-friendly operating menu
- Setpoint input by numerical entry or keys
- Operating modes: Manual, Ramp, Auto
- MES with entry of order information
- Manual input of quality appraisal: good/ bad
- Bar graph for order in progress
- Trend chart for process evaluation
- Alarm overviews and logs
- Personalized alarm configuration
- Host computer or internet connectivity
- Language selectable
- Personalized functions, evaluation routines and HMI

Optional production overview

- Order overview for all lines
- Operating mode
- Material consumption
- Length produced
- Remaining time for order
- Current throughput
- Current speed
- Current weight per meter