

EQUIPMENT ENGINEERING
GROUP

Operator manual
PACK SPLITTER
Outo Kumpu Oy.
Finland

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2.13 – P07 Jogger

EMG OUTO KUMPU

P07 Tasoitin

14:51:53
15/06/2009

Parameters

Length (mm)
0

Width (mm)
0

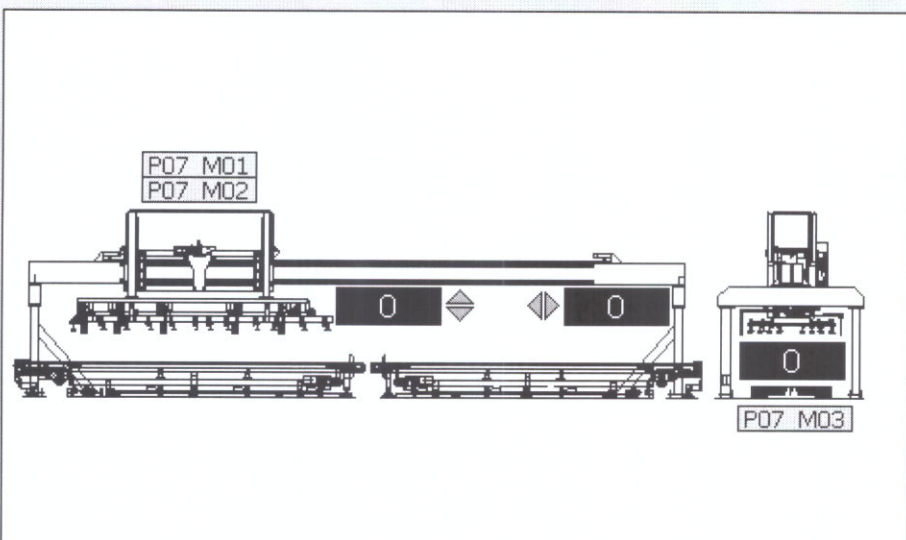
Tickness(mm)
0.00

Quantity
0 / 0

Status

Data OK
CYCLE OFF

AUX NOT OK
VACUUM OFF



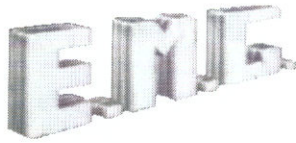
Jog Mode	Vacuum ON	Uncoupling		Alignement		Sheet centering	
MDI/Jog Mode	Vacuum ON/OFF	Enable	NOT Enable	Enable	NOT Enable	Enable	NOT Enable

Home
←
→

Horizontal	Vertical	Jogger
Homing OFF	Homing OFF	Homing OFF
Homing NOT OK	Homing NOT OK	Homing NOT OK

ACK Alarm

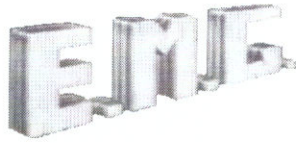
Number	Description
1	<p>MDI/JOG mode: available in MANUAL status ONLY.</p> <p>In JOG MODE horizontal axis move untill the related button forward/revind is pressed.</p> <p>In MDI MODE if the operator press the forward button the horizontal axis moves to the pick position, if revind button is pressed the horizontal axis moves to the place position.</p>
2	<p>Vacuum ON/OFF: available in MANUAL status ONLY.</p> <p>To enable/disable the vacuum pump.</p>
3	<p>Uncoupling Enable/Disable: available in MANUAL status ONLY.</p> <p>To move up/down the jogger front side .</p>
4	<p>Alignement Enable/Disable: available in MANUAL status ONLY.</p> <p>To open/close alignement forks.</p>
5	<p>Sheet centering Enable/Disable: available in MANUAL status ONLY.</p>



1.2 – Machine status banner

Number	View command	Description		
1	<div style="border: 1px solid black; padding: 5px;"> <p>Parameters</p> <p>Length (mm)</p> <p style="background-color: black; color: white; text-align: center;">0</p> <p>Width (mm)</p> <p style="background-color: black; color: white; text-align: center;">0</p> <p>Tickness(mm)</p> <p style="background-color: black; color: white; text-align: center;">0.00</p> <p>Quantity</p> <p style="background-color: black; color: white; text-align: center;">0 / 0</p> <p>Status</p> <p>AUTOMATIC</p> <p>CONTINUOUS Cycle</p> <p>Data OK</p> <p>CYCLE ON</p> <p>AUX OK</p> <p>VACUUM ON</p> </div>	<div style="border: 1px solid black; padding: 5px;"> <p>MAINTENANCE</p> <p>MANUAL</p> <p>AUTOMATIC</p> <p>SINGLE Cycle</p> <p>CONTINUOUS Cycle</p> <p>Data OK</p> <p>Data OK</p> <p>CYCLE OFF</p> <p>CYCLE ON</p> <p>VACUUM OFF</p> <p>VACUUM ON</p> <p>AUX NOT OK</p> <p>AUX OK</p> </div>	<p>Every page contains in the left side the Machine status banner. It reports the actual machine status, such as:</p> <ul style="list-style-type: none"> -Actual sheet size. -Programmed/actual sheets. -Machine working mode: maintenance/manual/automatic. -Automatic Cycle Mode: "SINGLE Cycle", "CONTINUOUS Cycle". -Download data control: "Data OK" in green in colour in case of right downloaded data. -Cycle status: "CYCLE ON/OFF". -Vacuum pump status: VACUUM PUMP MUST BE ON TO BE ABLE TO USE THE MACHINE. -Auxiliaries circuits status: "OK/NOT OK". <p>CIRCUITS MUST BE ON TO BE ABLE TO USE THE MACHINE.</p>	

Note: all blacks fields are not editable, only fields in light grey/white could be modify.



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2 Pages

2.1 – Main page

From the “Main page” the operator can access to the whole plant.

Number	Description
1	PRODUCTION PARAMETERS: pressing this button operator can access to the production parameters setting page.
2	COMMANDS: pressing this button operator can access to the production commands page.
3	STATUS MCC: pressing this button operator can access to the plant status page.
4	SETTINGS: pressing this button operator can access to the plant settings pages (machines sizes, timers,



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	offsets,etc...). The access to this page is manage by PASSWORD
5	SPEEDS: pressing this button operator can access to the motors speed settings page. The access to this page is manage by PASSWORD
6	SERVICES: pressing this button operator can access to the system services page.
7	ACK Alarm: to acknowledge alarms.
8	HORN Silence: to silence the acoustic device in case of alarm.
9	Next: pressing this button operator can access to the next page.
10	Back: pressing this button operator can access to the previous page.
11	Home: pressing this button operator can access to the Main page.



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2.2 – Production parameters

OUTO KUMPU		Tuotantoparametrit / Production Param.	17:33:53 11/06/2009
Parameters	Description	Values	
Length (mm) 0	Length of the sheet (mm):	0	
Width (mm) 0	Width of the sheet (mm):	0	
Thickness(mm) 0.00	Thickness of the sheet (mm):	0.00	
Quantity 0 / 0	Programmed sheets number:	0	
Status			
Data OK			
CYCLE OFF			
AUX NOT OK VACUUM OFF			
Download data			
		ACK Alarm	

This page should be used by operator to set all the parameters needed for the production.

Parameters must be downloaded pressing the related button “Download data”, if all numbers are ok its will be moved from the right side (in white) to the left side (in black) and the data flag (“Data OK”) in the status banner will be shown in green.



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2.3 – Commands

		Komennot/Commands			17:21:22 11/06/2009
Parameters		Commands			Cycle time
Length (mm) 0		START JOB			Single/ Continuous
Width (mm) 0					
Tickness(mm) 0.00		END JOB ON P03 COMPANY pallet			BLOW
Quantity 0 / 0		END JOB ON P04 CUSTOMER pallet			
Status		END ACTUAL JOB			Disable
Data OK CYCLE OFF		PALLET P04 NOT IN EDGE POSITION			Enable/ Disable
AUX NOT OK VACUUM OFF		CONFIRM EDGE POSITION			
Last job sheets number 0000		Vertical >20mm HORIZONTAL /JOGGER DISABLE			System
Homing		Horizontal Vertical Jogger			
Abort		Abort Abort Abort			
		Homing OFF Homing OFF Homing OFF			RESET Automatic cycles
		Homing NOT OK Homing NOT OK Homing NOT OK			
		ACK Alarm			

This page contains all commands needed to manage the pack splitter station.

Number	Description
1	START JOB: pressing this button operator can start the programmed job.
2	END JOB ON P03 COMPANY pallet: at the end of the actual job the operator has to press this button to activate the pallet unloading in the COMPANY AREA (left side).
3	END JOB ON P04 CUSTOMER pallet: at the end of the actual job the operator has to press this button to activate the pallet unloading in the CUSTOMER AREA (right side).
4	END ACTUAL JOB: this button must be pressed at the end of pallets unloading (pallets at the end of the chain conveyors) to enable a new START JOB command. The button has to be pressed ONLY if operator pressed only one of the two END job buttons (P03 or P04), if both buttons was pressed the system by it self executes the END ACTUAL JOB command.
5	SINGLE/CONTINUOUS CYCLE: if continuous cycle is selected the system executes his job without interruptions. In case of single cycle the system moves one sheet at time waiting the START JOB