



**Rockwell
Automation**

Winder & Unwinder

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11 • 08 • 2023



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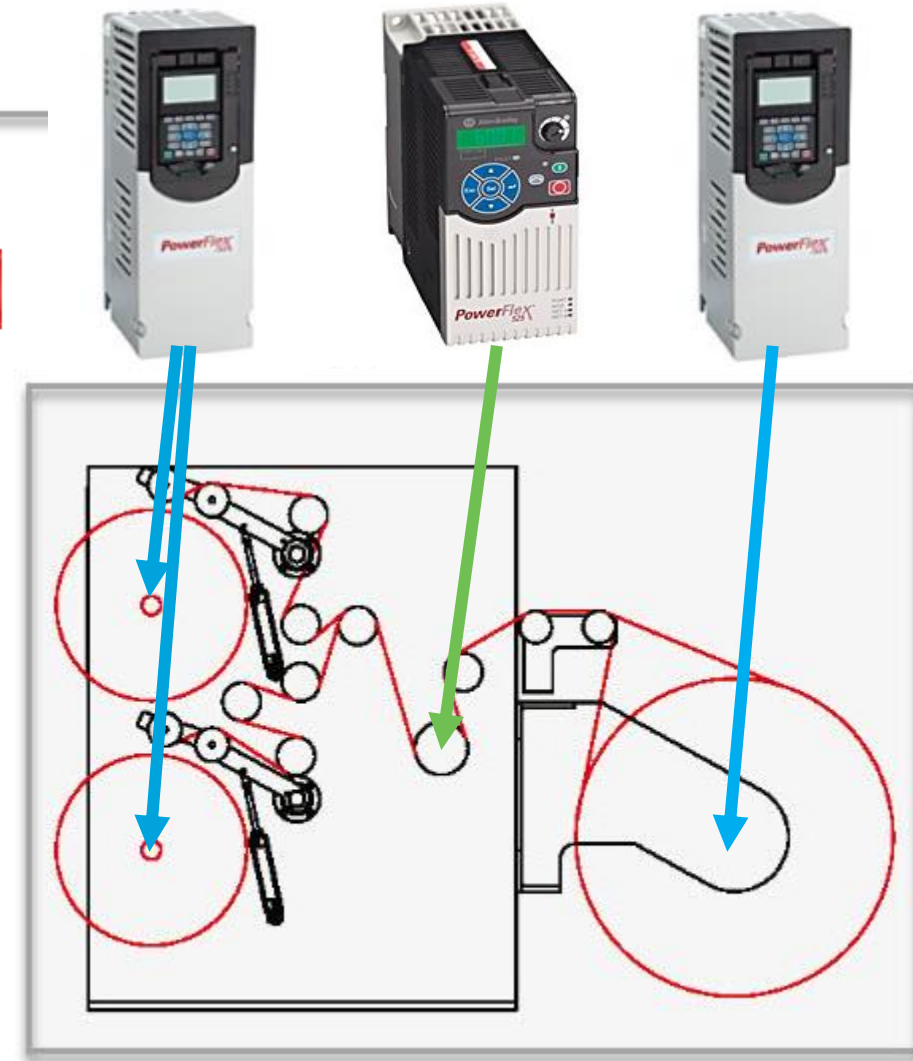
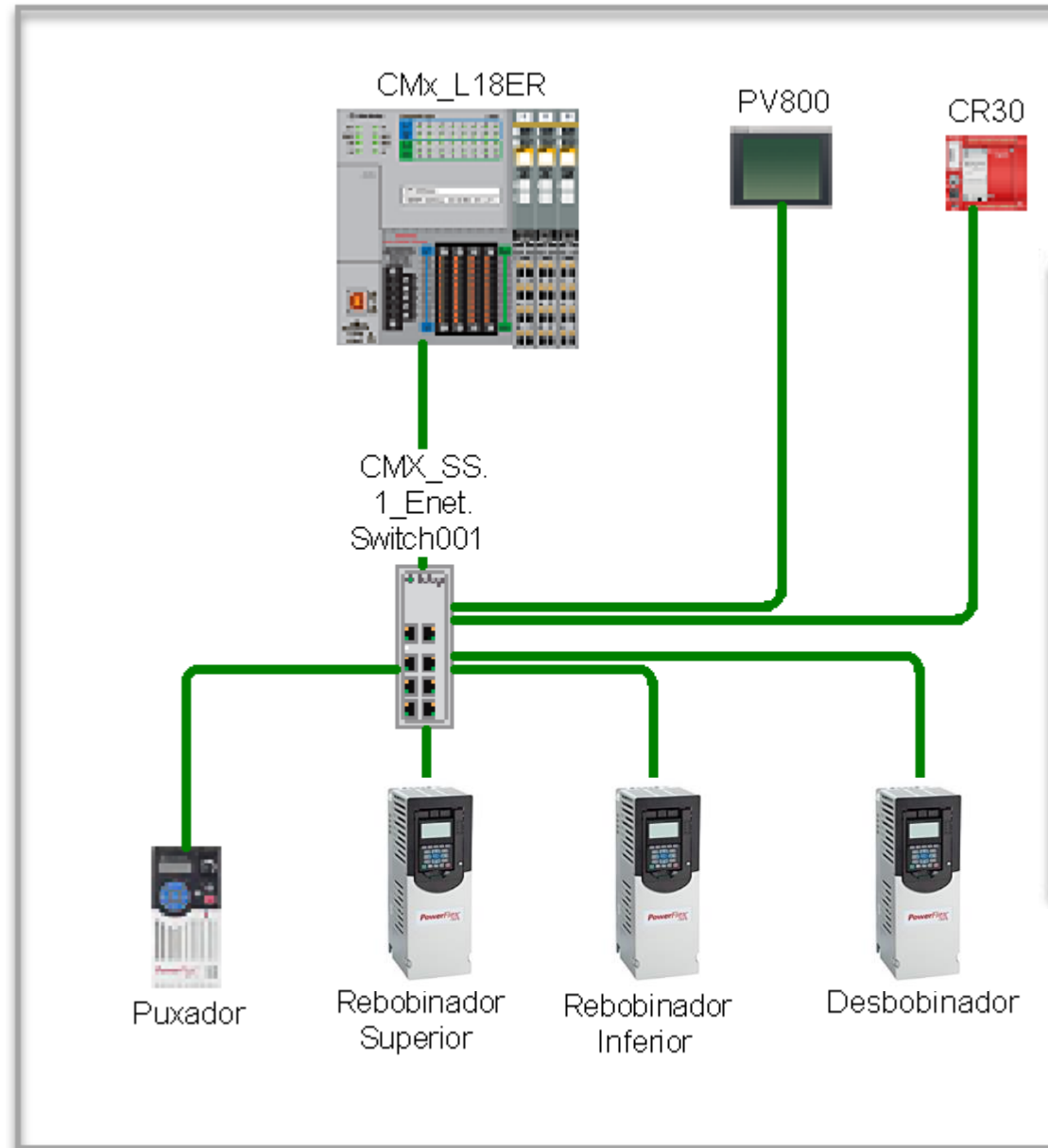
Solução

Desbobinador PF753

Bobinadores PF753

Controle Torque

- 1769-L19ER
- PanelView 800
- (1x) PowerFlex 525
- (3x) PowerFlex 753
- Stratix 2000
- CR30
- Cortina de Luz
- Scanner



Solução

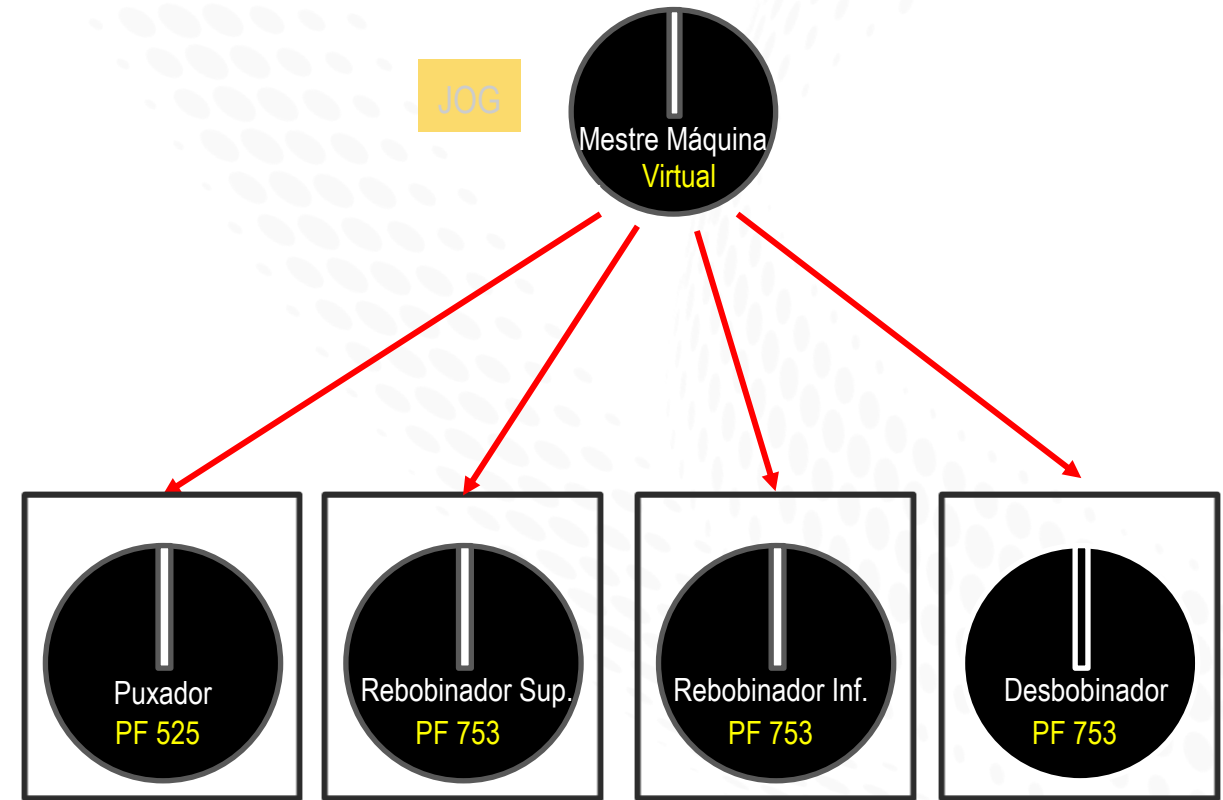
Bobinadores e Desbobinador com PF 75x

Entramos com a configuração para cada um dos eixos:

- Diâmetro do eixo
- Relação de transmissão
- Velocidade nominal do motor

Com essas informações, calculamos uma relação de qual referência de velocidade precisamos enviar para os drives.

Desbobinador e Rebobinadores, o motor está no eixo central, o controle de torque é realizado através do feedback da célula de carga ou balancin.

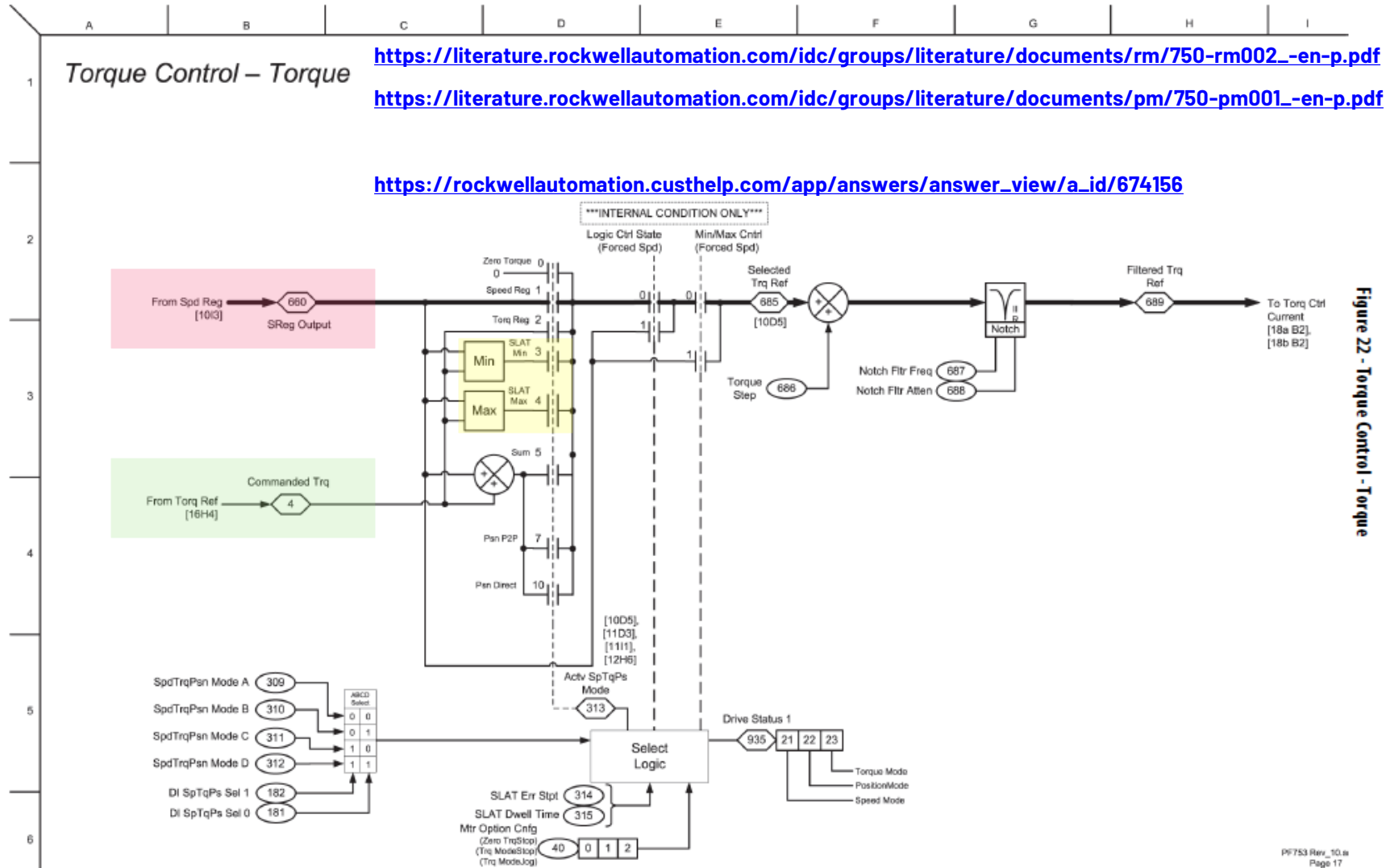


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Solução

Motor eixo central com PF75x - Modo de Controle SLAT - Speed Limited Adjustable Torque

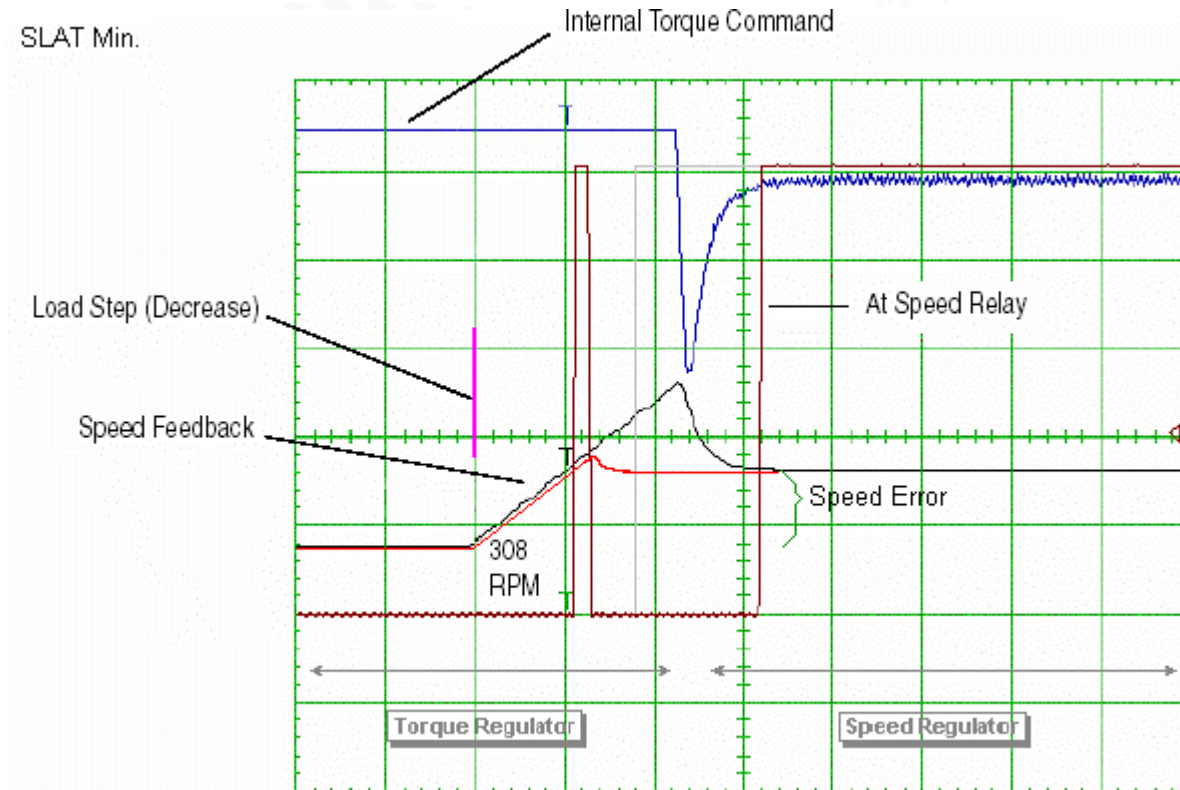
Rockwell Automation Publication 750-PM001-0-B1-P - November 2018



Solução

Motor eixo central com PF75x - Modo de Controle SLAT - Speed Limited Adjustable Torque

Parameter	Unwinder	Winder
35 [Motor Cntl Sel]	3 "Induction FV"	3 "Induction FV"
125 [Pri Feedback Select]	Point to port and appropriate parameter for encoder (if open loop, leave at default)	Point to port and appropriate parameter for encoder (if open loop, leave at default)
545 [Speed Ref A Sel]	Port 0 Parameter 571 [Preset Speed 1]	Port 0 Parameter 87x [Port x Reference] (where x is the port that is the speed reference source) Set this value to the line speed + 10%
571 [Preset Speed 1]	Set to a negative speed equal to the fastest that the unwind can go backward if the line breaks	n/a
308 [Direction Mode]	1 "Bipolar"	1 "Bipolar"
309 [SpdTrqPsn Mode A]	4 "SLAT Max"	3 "SLAT Min"
675 [Trq Ref A Sel]	Port 0 Parameter 676 [Trq Ref A Stpt]	Port 0 Parameter 676 [Trq Ref A Stpt]
676 [Trq Ref A Stpt]	PLC program will vary this torque based on roll diameter	PLC program will vary this torque based on roll diameter



https://rockwellautomation.custhelp.com/app/answers/answer_view/a_id/674156



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Conclusão

Explorar e vender os recursos que o cliente tem em mãos, quando adquire nossas famílias de drives e acionamentos.

Esses recursos agregam muito valor aos nossos produtos.

- **Flexibilidade**
- **Conectividade**
- **Diagnosticos preditivos**
- **Safety Integrado**



Referências

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