

**HSL-CCSD1
CROWN CORK & SEAL DECORATOR
HIGH SPEED CONTROL PACKAGE**

The Systems Engineering HSL-CCSD1 Crown Cork & Seal Decorator High Speed Control Package provides:

- ◇ **Reduced Scrap:** Accurate miss-loaded can print trip and blow-off reduces number of good cans blown-off for every miss-load to just two (the bad can and the can on the opposite mandrel).
- ◇ **Improved Quality:** Eliminates silver cans, partially printed cans, and partially varnished cans from going down the line. Eliminates inside Litho problems (printed mandrels) as well.
- ◇ **Quality Control (Select-A-Can) Blow-off:** Allows verification of print quality for each blanket and mandrel by allowing the operator to blow off a can from a selected mandrel. Allows troubleshooting cut blankets, etc.
- ◇ **Quick Pay-off:** With the reduction in spoilage incurred, the HSL-CCSD1 typically pays for itself in just a few months.



Features

- Performs high-speed control functions of Crown Cork & Seal Decorator up to 2,400 Cans Per Minute (machine mechanically permitting). This includes speed compensated print and varnish trip which eliminates inside deco and varnish problems, and single space pin chain (linear vacuum conveyor) blow-off which reduces scrap.
- High-speed logic package which interfaces with existing control system. Interfaces directly with machine mounted resolver, no can/no print sensors (both drive and offside) and all trip and blow-off solenoids. Built in PLS (Programmable Limit Switch) provides all machine timing, eliminating the need for an additional PLS.
- Performs the following control functions:
 - Detection of miss-loaded cans.
 - Accurate damaged can blow-off prior to the print station eliminates cut blankets.
 - Speed compensated print trip control (single mandrel trip).
 - Speed compensated varnish trip control (single mandrel trip).
 - Speed compensated single space pin chain (linear vacuum conveyor) blow-off.
 - Select-a-can QC pin chain blow-off.
 - Alarm detection: infeed track jam and timing signal fail detection.
 - Data Acquisition: Total number of good cans printed, total number of blow-offs, total trips per side (drive and offside), trips per spindle per side, etc. (for both current and last shift).

General Description

The HSL-CCSD1 Decorator high speed logic package is an electronic upgrade for the Crown Cork & Seal Decorator which reduces excess blow-offs (scrap) by tripping and blowing off the minimum number of cans (two, the bad can and the can on the opposite spindle) for each miss-load. In addition, it improves quality by eliminating silver and partially printed cans down the line as well as eliminating inside litho problems. The package detects miss-loaded cans, performs speed compensated print trip, varnish trip, and single space pin chain (linear vacuum conveyor) blow-off at speeds up to 2,400 CPM. The package also provides select-a-can pin chain blow-off for print quality verification, alarm detection, and data collection.

The package is not a dedicated "black box", but instead is implemented using the high performance Systems M4500 PLC/PLS module which allows easy customization by either SEA or the end user. The module is programmed using the DOS based SYSdev software programming package which allows programming in any combination of Ladder Logic or high-level (subset of "C"), as well as perform on-line monitoring and trouble-shooting. The module incorporates a built-in PLS which interfaces directly with the machine mounted resolver and provides all machine timing, eliminating the need for an external PLS.

Print and Varnish Trip

Speed compensated print trip at speeds up to 2,400 CPM is incorporated in the HSL-CCSD1 package to compensate for the mechanical/pneumatic trip response of the print trip. The print trip is accurately retracted "out" between the spindle ahead and the miss-loaded spindle and extended back "in" between the miss-loaded and the following spindle at all speeds. This reduces scrap by fully printing the can ahead and behind the miss-load and also eliminates inside litho problems by assuring that the miss-loaded spindle is completely skipped. The varnish trip control algorithm incorporates the same speed compensation algorithm incorporated in the print carriage control and thus provides fully varnished cans ahead and behind the miss-load while still assuring that the miss-loaded spindle is completely skipped.

Pin Chain (Vacuum Conveyor) Blow-off

The pin chain blow-off incorporates speed compensation to compensate for the response time of the blow-off solenoid regardless of machine speed. This allows accurate single space rejection of miss-loaded (empty space) cans and re-start blow-offs from the pin chain at speeds up to 2,400 CPM. This eliminates silver and poorly printed cans down the line.



QC (Select-A-Can) Blow-off

The Quality Control (select-a-can) feature allows the operator to dial in a mandrel number, either at the remote PB station or from the keypad of the HSL-CCSD1, and blow-off one can printed on each side for that mandrel. Mandrels 1 through 24 can be individually blown-off this way to verify the print quality of each mandrel. This allows the quick determination of a cut blanket, etc.

Two other select-a-can blow-off modes are also available: 8 or 24 can blow-off. These modes blow-off 8 or 24 consecutive cans starting with blanket #1. This allows all 8 blankets or all 24 spindles to be checked at one time. In addition, the HSL-CCSD1 can be set up to automatically blow-off 8 consecutive cans, starting at blanket #1, on a periodic basis (i.e. once every hour).

Alarm Detection

The package detects the following alarms: *Infeed Track Jam* and *Timing Signal Fail*.

The *Infeed Track Jam* alarm occurs when 6 consecutive empty mandrels are detected on either side by the “no can/no print” sensors after the can gate is opened.

The *Timing Signal Fail* occurs when any of the timing signals generated in the PLS section fail to change state periodically while the machine is running. The above alarms can be used to stop the machine when the respective alarm occurs.

“HSLCCSD1” SETUP PROGRAM

The “HSLCCSD1” setup program is a DOS based menu driven program which allows the user to easily view the HSL-CCSD1 data or alter the HSL-CCSD1 setup variables using an IBM PC or compatible. These variables include the print and varnish response times and the pin chain/QC blow-off parameters. In addition to setting the variables, “HSLCCSD1” can be used to set the machine timing, view the current and last shift data, view the trips per spindle, download the HSL-CCSD1 application program to the M4500 as well as download and upload the setup data to the M4500.

Data Collection

The following data is collected for both the current shift and the previous (last) shift: Total number of good cans printed, total number of cans blown-off, total number of trips per side (drive and offside), total number of restart blow-offs, total number of manual blow-offs, total number of select-a-can QC blow-offs, and the total trips per spindle per side. This data can be viewed locally on the display of the HSL-CCSD1 by either the operator or production control personnel. This information is updated (“current” shift transferred to “last” shift) based on the change of state of a discrete input.

In addition to the shift data collection, a separate buffer is available to collect trips per spindle counts as a diagnostics aid to the operator for trouble-shooting a loading problem on a specific mandrel. Unlike the shift data, these counts can be reset manually by the operator at will.

An optional communications board (S4516) is also available such that this data can be transferred to a host A-B PLC using the DF1 protocol, a MODICON PLC using the MODBUS protocol, or a Siemens (545) PLC using the S3000 network.

HSL-CCSD1 Keypad / Display

The keypad of the HSL-CCSD1 contains 24 keys consisting of data display commands, setup commands, and a numeric keypad. The display of the HSL-CCSD1 is a 2 line by 40 character back-lit LCD display which displays the selected data and setup menus. The keypad/display can be used by the operator to view the current and last shift data as well as the trips per spindle diagnostic data. In addition, the keypad/display is used to activate the select-a-can QC blow-off feature and can be used by authorized personnel (passcode or key switch protected) to adjust the timing and all setup parameters.



Specifications

Power Requirements:

Voltage: 100-240VAC, 50/60HZ
Current: 0.5 Amps @ 115VAC
0.25 Amps @ 230VAC

Temperature Ranges:

Operating: 0 to 55°C
Storage: 0 to 70°C

Resolver Interface:

Resolver Type: Systems Electronics Group
RSV34-MS1 or equivalent (also can be
paralleled with existing resolver/PLS)

Resolver Cable: Systems Electronics Group
RSV-RSCBLE-XX

Control Inputs:

Voltage Range: 10-30VDC
Input "On" Voltage (min): 10.0 volts
Input "On" Voltage (max): 30.0 volts
Input "Off" Voltage (max): 5.0 volts
Input Current (max): 15 milliamps @ Vin=30V
Optical Isolation: 1500 Vrms

Outputs:

Voltage Range: 10-30VDC
Output "On" Voltage (min): VCC-2.00 volts
Output "On" Voltage (max): VCC-0.25 volts
Output "Off" Voltage (max): 1.5 volts
Output "On" Current (max-cont): 0.5 Amps DC
Output "On" Current (100msec): 3.0 Amps DC
Optical Isolation: 1500 Vrms

Ordering Information

The HSL-CCSD1 package is provided for back-panel mounting inside the existing user's control cabinet. In addition, a NEMA 12 enclosure can be purchased to house the HSL-CCSD1 if required space is not available in the existing user's cabinet. The part number for the optional NEMA 12 enclosure is HSL-CD4-ENCL. The order number for the HSL-CCSD1 is as follows:

Part Number

Description

HSL-CCSD1

Crown Cork & Seal Decorator high speed control package consisting of a pre-wired sub-panel (17" X 17" X 8") for mounting in the existing user's control cabinet including the following:

- 1ea. M4500 PLC/PLS module (with required I/O boards)
- 1ea. D4591 Display/Keypad
- 1ea. HSM-CCSD2 User's Manual
- 1ea. HSM-CCSD2 Keypad Quick Reference Manual
- 1ea. HSM-CCSD2 Program Disk
- 1ea. M4500 User's Manual

HSL-CCSD1 Options (*purchased separately*)

The following items can be purchased separately as required or desired:

Part Number

Description

HSL-QCSTA

Remote Select-A-Can PB station

HSL-DSP

Remote RPM/Position Display

HSL-CD4-ENCL

NEMA 12 enclosure for HSL-CCSD1 (20" X 20" X 10")

RSV34-MS1

Resolver (required if machine is not already equipped with resolver)

RSV-RSCBLE-XX

Resolver Cable

S4516

Communications Board

SYSTEMS Electronics Group, Inc.

Division of **SYSTEMS Engineering Associates, Inc.**

14989 W. 69th Ave., Arvada, CO 80007

Telephone: (303) 421-0484 FAX: (303) 421-8108 www.sea-seg.com
