



User Manual

SDE Visualisation





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1 Introduction

1.1 Preamble

We thank you for choosing this SDE application. During the development phase of the entire system SDE was paying particular attention to an easy operability of the computer program. Also the expandability with respect to future developments was considered.

Primary, this system was engineered in order to produce timber. The basic configuration consists of the measuring unit, the optimisation Personal computer including a VGA-Monitor and a printer. In case of maximum configuration a second personal computer for process visualization will be included in the system. All computers can be implemented in a network structure. This enables the user to access topical data without affecting the production process.

Installation

The installation of the SDE optimization system is carried out by the SDE GmbH itself. During the installation and ramp up phase of the saw line we require a electrician and a mechanist (provided by customer) in order to carry out all installation activities, in particular the fixation of measuring frame and pulse encoder. Further information will be provided in the project engineering phase.

Maintenance

In the general our PC's are maintenance-free. From time to time keyboard, monitor and printer should be cleaned from dust with a soft and dry tissue. Occasionally the cooling unit (fan must rotate) should be checked. A failure of the cooling unit results in a overheating of the PC. Normally the Power supply unit will be destroyed in such cases.

Update of the Computer programs

Customization of our programs is an enormous strength of all SDE computer programs. Modification according to customer's wishes can be carried out easily after issuing a quotation. It is part of our philosophy to improve our programs continuously. Clues and Proposals that are coming from field experience are welcome anytime and will be evaluated accurately.

Important Information

SDE GmbH disclaims liability for damages which originate from the use of the described device or the described programs or from instructions given in writing or orally. The contents of this user manual as well as the function of the described programs can be changed any time without previous announcement. The buyer will get updated program versions on request from SDE. These updates are free of charge unless other agreements have been made before. There is no obligation of SDE to notify the customer if a new program version is being released. All rights on this edition are reserved to the publishers. Without written approval of the company SDE it is not allowed to copy this manual or parts of this manual or making hard copies (on microfilm or any other form).

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1.2 Abbreviations and symbols

Symbol	Bedeutung
	Chipper blade
	Block conveyor (Frame red: Conv. Not running) (Frame green: Conv. is moving)
	Light barrier
	Cross conveyor

Abbreviation	Meaning
BS	Board Separator
СС	Cross Conveyor
ifo	In front of

Symbol	Bedeutung
\bigcirc	Mechanical switch
0	Centring Roller
Ī	Measuring device
• •	Prick roller



2 Main menu

Overview 2.1





2.2 Button functions right side

R1	R2	R3	R4	R5	R6	R7	R8	R9	R10
Function	Automatic Input Log/Cant ON/OFF	BS: Upper Roller 1-8 open/ <u>close</u>	BS: Side Roller 1-8 up/ <u>down</u>	Release Saw Transport ON/OFF	Entire Line slow	Roller behind Chipper up/ <u>down</u>	CC ifo Chipper interval	CC behind saw interval	Cant Conveyor 1 forward
R11	R12	R13	R14	R15	R16	R17	R18	R19	R20
<u>Chipper</u> open	get log			Release Centring Transport ON/OFF	Conveyor behind BS Forward/ <u>backward</u>		Meas. Area Transport Forward/ <u>backward</u>	Cant separator behind saw	Cant Transport Belt 1 forward
R21	R22	R23	R24	R25	R26	R27	R28	R29	R30
Line START / STOP	Cant/ Log	Chipper Centring Unit open	Chipper Centring Unit close	Release Infeed Transport ON/OFF				CC ifo chipper Impulse <u>Tip</u>	Cant Transport Belt 2 forward
D21	Daa	D22	D2/	D25	P26	D27	D29	P20	P40
Accept Log	Input Cant	Centring in front of chipper up/ <u>down</u>	Centring in front of chipper open/ <u>close</u>	Infeed Tip <u>line</u> <u>forward</u>	Entire Line back	Centre arms Infeed close	Prick Roller open/ <u>close</u>	Cant separator ifo Chipper	Cant Conveyor 2 forward

2.3 Button functions left side

L1	L2	L3	L4	L5	L6	L7	L8
Chipper ON/OFF	Saw is running	Main Hydraulic ON/OFF	Hydraulic Infeed ON/OFF	Servo- Hydraulic ON/OFF	Automatic Cant ON/OFF	Automatic Logs ON/OFF	Horn <u>light test</u>
L9	L10	L11	L12	L13	L14	L15	L16
Automatic Start Up ON	Automatic Start Up OFF					Control Voltage partition	Delete Error

ON



3 Operate the system

In order to have a quick access to all sections of the system there are several hardware buttons ready to be used.

3.1 General functions	No.	Button	Image: Complete saw line		
Activation of the 2 nd function (double assignment)	R1	Function			
The entire line from the Infeed to the end (area behind saw) runs with speed "slow"	R6	Entire Line slow	Box 2		
Entire saw line starts and stops	R21	Line START / STOP			
Interaction with computer program "Optimization"	R22	Cant/ Log			
Entire saw line back	R36	Entire Line back			
Control of main hydraulic pump	L3	Main Hydraulic ON/OFF			
Control of hydraulic pump for the Infeed area	L4	Hydraulic Infeed ON/OFF			
Control of hydraulic pump for servo plunger of the band saw (horizontal movement)	L5	Servo- Hydraulic ON/OFF	13000000000000000000000000000000000000		
Cant return brings cants back into main line automatically.	L6	Automatic Cant ON/OFF	positioning e T		
Logs will be fed into main line automatically.	L7	Automatic Logs ON/OFF	3000 1 3000 3000 set 2500 3600 1 3600 set 3 1 2 4		
Activation of the horn (2 nd function light test)	L8	Horn light test	box 0 2700 N 2700 set		
Ramp up of all drives, computer program will start all components successively.	L9	Automatic Start Up ON	positioning 0 KG		
Immediate Stop of all drives within the saw line	L10	Automatic Start Up OFF	998		
Activation of the Control Voltage of one part of the saw line	L15	Control Voltage partition ON	delete 0 0000 Log gap		
Reset after the occurrence of an error	L16	Delete Error			



3.2 Manual operation

Normally the log data that is coming from the program "Pattern Optimization". The operator has the option to key in particular data manually. The data of one log will be transmitted by pressing the "active" button to the buffer memory.

No tick on box "Chipper active": Chipper is not active and will ignore the incoming logs.

Image: Manual Operation

manual operation width 1 width 2 width 3 width 4 width 5 50 40 40 50 length heigh box ox 300 200 3 image: state state

3.3 Buffer Memory

The buffer memory field is separated into two sections. Every time when the operator presses the button "active" (for manual operation) or log data will be sent from the program "Pattern Optimization" this buffer is filled with relevant log data. This buffer is working according to first in – first out principal.

After passing the chipper the current log position will disappear from the lower section. After passing the band saw the position will also disappear from the upper section.

Image:	Butter	Memory	

	cur.no.	cant / log	width 1	width 2	width 3	width 4	width 5
1	8	log	50,0	50,0	60,0	50,0	50,0
2	9	cant	50,0	50,0	60,0	50,0	50,0
3	10	cant	50,0	40,0	40,0	40,0	50,0
4							
1	8	log	50,0	50,0	60,0	50,0	50,0
2	9	cant	50,0	50,0	60,0	50,0	50,0
3	10	cant	50,0	40,0	40,0	40,0	50,0
4							,

Imagai Data / Carviaa

3.4 Data / Service

	innage. Data / Service
With the help of the menu to check resp. impact particular functions of the system.	-data / service
Test active Simulation of saw line operation, the computer program will assume that saw and chipper run.	250 Cutting height saw
Cutting height saw	
Cutting height canter	250 Cutting height canter
Service position Components of the saw line like band saw and chipper go into a parking position.	serviceposition
Get log from scanner Dimension of last log will be put in the optimization again.	get log from scanner
Accept log – Compare Chapter 3.6, R31	Accept log
Input canter – Compare Chapter 3.6, R32 Cant / Log - Compare Chapter 3.1, R22	input cant
	cant / log



3.5 Measuring areaNo.ButtonImage: Measuring areaThis function controls the conveyor of
the Measuring area. By using the key
"function" (R1) the conveyor will go
backwards (key combination for 2ndR18Meas.
Area
Transport
Forward/
BackwardMeasuring area. By using the key
"function" (R1) the conveyor will go
buckwards (key combination for 2ndR18Meas.
Area
Transport
Forward/
Backward

3.6 Infeed	No.	Button	Image: Infeed
This function sets an automatic Input of Cants and logs. There is no need for a manual intervention.	R2	Automatic Input Log/Cant ON/OFF	
Activation of the conveyor of the Infeed	R25	Release Infeed Transport ON/OFF	
The Infeed conveyor is moving as long as the operator is tipping this button.	R35	Infeed Tip line forward	
Exactly one log will be fed into the main line.	R12	get log	
Acceptation of one of the cutting pattern proposal (compare program "Pattern Optimization")	R31	Accept Log	
Input of Cant (manual intervention)	R32	Input Cant	
The Centre arms go in position "close" as long as the button is pressed. The cant resp. logs will be centred.	R37	Centre arms Infeed close	
Activation of Prick Rollers (log an be turned)	R38	Prick Roller open/ <u>close</u>	

3.7 Centring in front of

Cnipper	No.	Button	Image: Centring of front of Chipper
This unit has a conveyer that can be switched on/off separately with this button	R15	Release Centring Transport ON/OFF	00
Lifting / Lowering the pressure rollers of the centring.	R33	Centring in front of chipper up/ <u>down</u>	00
Open / Close of the pressure rollers unit	R34	Centring in front of chipper open/close	



2.0 Obiener			Image: Chipper and Chipper Centring
3.8 Unipper	No.	Button	Unit
Conveyor that is going through Chipper	R5	Release	
and Intermediate Control Unit can be		Saw	
switched ON/OFF.		ON/OFF	
Lifting / Lowering of Roller direct at the	R7	Roller	
exit of the Chipper.		behind	
		Chipper	0000
Chipper and all reliers open completely	R11	Chipper	
Chipper and all rollers open completely.		Open	
Opening of Chipper Centring Unit	R23	Chipper	2700 2700
		Centring	3600
		Unit	
Closing of Chippor Contring Unit Close	R24	Chipper	
Closing of Chipper Centring Onit Close	1127	Centring	
		Unit	
		close	
Turn ON/OFF of Chipper unit	L1	Chipper	
		ON/OFF	

39 Band saw

3.9 Band saw	No.	Button	Image: Band saw
This image shows the main band saw	L2	Saw	
with all blades. The position of the		runnina	2500 3600
blades is given in the red box (upper		5	2 1 2 4
box: set point, lower box: actual value).			3 1 2 4

3.10 Board Separator (BS)	No.	Button	Image: Board Separator (BS)
Upper rollers of board separator will be opened resp. close (2 nd function).	R3	BS: Upper roller 1-8 open/ <u>close</u>	o o o o dididid
Side rollers of this board separator are located on the left side of the conveyor. This function opens (resp. closes) the side roller.	R4	BS: Side roller 1-8 up/ <u>down</u>	0 0 0 0 d d d d

3.11 Area behind band saw	No.	Button	Image. Cross conveyor behind saw.
Cross conveyor behind band saw is put in mode "interval" . The CC is moving only in particular time frames.	R9	CC behind saw interval	
Conveyor behind BS (left side) can be switched ON/OFF.	R16	Conveyor behind BS Forward/ <u>Backwards</u>	
Cant separator behind saw is moving.	R19	Cant separator behind saw	

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3.12 Cant return

Image: Cant return No. Button Cant R10 Conveyor 1 forward Cant Transport Belt 1 R20 forward 00000 box Cant Transport Belt 2 R30 forward 998 XXX delete ~~~~



3.13 Cross Conveyor in front

of Chipper	No.	Button	Image: Cross Conveyor in front of Chipper
Cross Conveyor is moving only in particular time frames.	R8	CC ifo Chipper interval	
Cross Conveyor is moving to the next stop position.	R29	CC ifo chipper Impulse <u>Tip</u>	
Normally one cant / Log is taken for the Cant conveyor 2	R39	Cant separator ifo Chipper	
Cant conveyor 2 is moving forward	R40	Cant Conveyor 2 forward	



4 Parameters

4.1 PLC Parameter

These Parameters are defined during the start- and introduction phase by SDE and should not be changed later on.

	-	C-parameter	PC-parameter				
pos.	DW		parameter-marking		0820		1
1	12	Infeed: distance spiked r	oller closed [*5cm]		KF +0	20	
2	14	Infeed: distance spiked r	oller open [*5cm		KF +0	20	
3							
4	16	Infeed: time spiked roller	closed at turn		KT 000.0	200.0	
5							
6	0	Infeed: distance lateral re	oller 1 closed [*5cm]		KF +0	0	
7	1	Infeed: distance lateral re	oller 2 closed [*5cm]		KF +0	1	
8	2	Infeed: distance lateral roller 3 closed ['5cm]				1	
9							
10	3	Infeed: distance lateral re	oller 1 open [*5cm]		KF +0	1	
11	4	Infeed: distance lateral roller 2 open [*5cm]				3	
12	5	Infeed: distance lateral roller 3 open [*5cm]				3	
13							
14	6	Infeed: distance pressur	e roller 1 ['5cm]		KF +0	30	
15	7	Infeed: distance pressure roller 2 ['5cm]				10	
16	8	Infeed: distance pressure roller 3 ['5cm]				7	
17							
18	9	Infeed: distance pressur	e roller 1 up ['5cm]		KF +0	1	
19	10	Infeed: distance pressure roller 2 up [*5cm]				1	
20	11	Infeed: distance pressur	e roller 3 un (*5cm)		KF +0	7	- 2

4.2 PC Parameter

<u>Mechanic</u> Kerf width – Enter width of Kerf

<u>Chipper overrun dimension / Saw overrun</u> When a cant runs through the saw line chipper and saw blades kept this distance to the cant. It should be save that the blades do not thought the cant.

Offset hand See Offset

Log gap Definition of gap between each log

Miscellaneous

Printer connected? – If there is a tick in this box the program will send all printer jobs to the printer interface. Otherwise the print information will be shown on the screen.

Check password – If the submenu "Parameter" is called the system will ask for a password. Without activation this option the operator can only read the parameter (recommended).

PLC-parameter	PC-parameter
mechanic Kerf width [1/10mm] chipper overrun dimension [1/10 mm] Saw 1/2 overrun dimension [1/10 mm] Saw 3/4 overrun dimension [1/10 mm]	offset hand 60 Offset kit chipper [//10mm] 0 0 Offset kit chipper [//10mm] 0 0 Offset saw 2 [//10mm] 0 0 Offset saw 2 [//10mm] 0 0 Offset saw 2 [//10mm] 0
	- log gap Minimum log gap [cm]
	- other F printer connect ? E Passaver advisor ?



4.3 Offset

This step is necessary to calibrate the saw line. This values are defined during the start phase of the saw line by SDE and should not be changed later.

4.3.1 Offset Chipper Canter

Enter the set point (width) of the cant for the first run. Than measure the with of the cant and fill it in box "actual".

Press "correct", the computer system calculates the correction value. This value appears at pc-parameter > offset hand. If necessary this value can be defined manually.



After the second run please measure the with of both cants (left and right) and fill in at "actual".







4.3.3 Offset Saw 2 - 4

Enter a realistic dimension (width) for tree cants you want to get after a third run.

Run the cant through the saw and measure the real dimension. Enter the real dimension at "actual" and press "correct".



5 IO-Test

5.1 Submenu I / O Test

This I/O Test offers the opportunity to valances of all bytes of the PLC.

- Input und Output bytes
- Input and Output words
- Marker words
- Counter
- timer

The valances can be shown in Dual, Decimal and Hexadecimal code. The data blocks 120, 121 and 122 are also displayed in this submenu. They are important fort he internal data exchange.

This submenu is a useful support during the ramp up phase of the saw line. It can also be used for the troubleshooting purpose.

5.2 Interbus

This Submenu is needed for troubleshooting if the field bus system is not working anymore. It is not relevant fort he operator and his work.

5.3 Topology Interbus

This submenu shows the Interbus Topology of the system. This system is responsible fort he data communication between the PC and all final control elements (e. g. Input sensors, relays, valves etc.)

I/O Test	Intert	ous	Topologie I	interbus		
	Wert	BIT	DEC	HEX	Datenbaust	ein
ait i	765432	10 76543	2 1 0	0000	v 120 121	122 *
Merker-Wort -	50 000000	00 00000	000 0	0000 0	0 0	0
Merker-Wort -	000000	00 00000	000 0	0000 2	0 0	0
Merker-Wort •	000000	00 00000	000 0	0000 3	0 0	0
Verker-Byte -	202 000000	0 0	0	00 5	0 0	0
Merker-Wort _	000000	00 00000	000 0	0000 6	0 0	0
Verker-Wort -	000000	00 00000		0000 8	0 0	0
Merker-Wort ·	000000	00 00000	000 0	0000 10	0 0 0	ő
Merker-Wort •	000000	00 00000	000 0	0000 11	2 0 0	0
Version				11	3 0 0 1 0 0	0
SPS: V 0,00 v	om 00.00.0000			18	5 0 0	0
				11	0 0	0 -
						J
						ISC Ende
	Imag	ge: I /	' O T	est		
		-				
I/O Test	Intert	ous	Topologie I	nterbus		
mmelstatusbits						
Konfiguration oder Lauf	caiffetdar					
mindestens ein Modul n	neldetFehler					
Periphasie Fehler Übertragsprocheller frei	nd nicht zahickozeweiet	feblerbatte	Station			
keine Verbischung zum I	riost	Toraconadree				
mindestens 1 defekte P	oripheriobus-Schnitstelle Fersbus-Schnitstelle	Fehler-Nr.		0		
and the second sec						
sstatus						
Bussegmente sind abg	escholtet					
					-	
		ao: 1	at c rl			ING ENGE
	ima	ge: II	nert	JUS		
I/O Test	Intert	us	Topologie I	Interbus		
A 💽	DO Keste					
	ro-sane					
1. Tastate	ar PC-Pult					
Ance at 1	if und 1					
	kasten 2 3					
2. Klemm	ter W					
2. Klemm Lingercode Schebercho						
C. Klemm Lingencode Scheberche Scheberche Schedht Lingencode	ichrank J					
Kiemm Largencode Schebercha	achrank 3					
2. Klemm Lingeroode Schebercha Lingeroode	kasten 1 5 15 15 15					
Z. Klemm Lingercode 3. Schabtt Lingercode 4. Klemm Lingercode Schabstrah	schrank 3 kasten 1 5 ke: W					
E. Kiemm Lingencode Scholtt Lingencode Lingencode Lingencode Lingencode S. Vippa-M S. Vippa-M	schrank 3 Kasten 1 3 tr.W Indul					
E. Kleener Largencode Schelter Largencode Schelter Largencode Schelter Largencode Schelter Largencode Schelter Schelter Schelter Schelter	schrank 3 kasten 1 5 kr.W					
Kimmi	schrank 3 kasten 1 5 ar W indul					
Schorts S	schrank 3 5 sadul					



6 Measuring Module

6.1 Main menu of the measuring module

This measuring module starts automatically when the computer system is ramped up. It is working in the background during the entire working process of the saw line.

The operator can use this menu in order to monitor momentary values during the measuring process of a log. This can be helpful in case of troubleshooting.

6.2 Parameter

This submenu contains the parameter of the measuring module. Theses parameters have to be set in a way that the saw line is working properly.

These parameters are defined during the installation phase and should only be changed by skilled persons.

6.3 Diagnostic

The program shows the length- und diameter profile of the current log.

RH-Vermessung Mounter	¥1.00 vom 10.0	07.2008	(c) SDE GmbH	
Vermessung / measuri	ng			
Durchmesser [mm] diameter [mm]		0		Programmende exit
Länge [cm] length [cm]		0		Parameter parameter
				Teststamm Create test log
				Diagnose diagnose
_ Diagnose / diagnose -				
Zyklus pro 100ms cycles 100ms	510		HW-Zählerstanc HW-counter	0
Zyklus gesamt cycles total	2800		32-Bit Zählerstar 32-Bit counter	nd 1000000000
Reset Zyklus /	reset cycles		Richt	ung / direction
			rückwi	ärts / backward
Im	age: Me	easu	ring moo	dule
rameter Vermessung / parameter	measuring			
ängenkorrekturfaktor [mm/m] correcting of length [mm/m] (xxxx)		1000	Testfunktion Test-function	en aktivieren aktiv
Minimaldurchmesser Vermessun Minimum diameter (mm)	g [mm]	50	Auf die SPS	zugreifen
Vindesweg LV frei bis Stamm gül	tig [cm]	5	Lichtvorhang	deaktivieren
Minimum distance light barrier fre Signaldauer an SPS (Zvklen)	e to log valid [cm]	19	Scanner des	IKUV
Duration of signal to PLC [cycles]		2000		
Durchmesser-Zugabe [mm] Diameter addition scanner [mm]		0		Abbruch ohne Speiche exit without save
				Ende mit Speichem save date and exit
Image: P	aramete	er of	Measuri	ng module
300	h h h	1 4		
50				
650				
500				
500				
400				
350	THRU WAR			
250		mmm		
200				
100				
⁵⁰		8	3 8 8	8 8 8 8 9
ہ کے تاریخ Länge(cm) ==> gemessen (mm) Länge(cm) == length (cm) ==> measured (mm) liength (cm) ==>	n N N N o geglättet (mm) Akto Smoothened (mm) mek	ps : ualisiere nut Grafi ly update graphin	w H	so 8 8 K N sten anzeigen Länge gemessen 3
334 334 0 1 2 2		Aktualisiere alles pdate everything	- From Gegie	ttet anzeigen Länge geglättet 3 smoothened length smoothened
0 3 3 0 3 333 5 7	0 Durcher 0 dameter		0	,
333 6 3 0 7 3 0 8 3	0 10 10 10 10 10	(cn)	0	Abbre
	00			
	Image	: Dia	agnostic	