

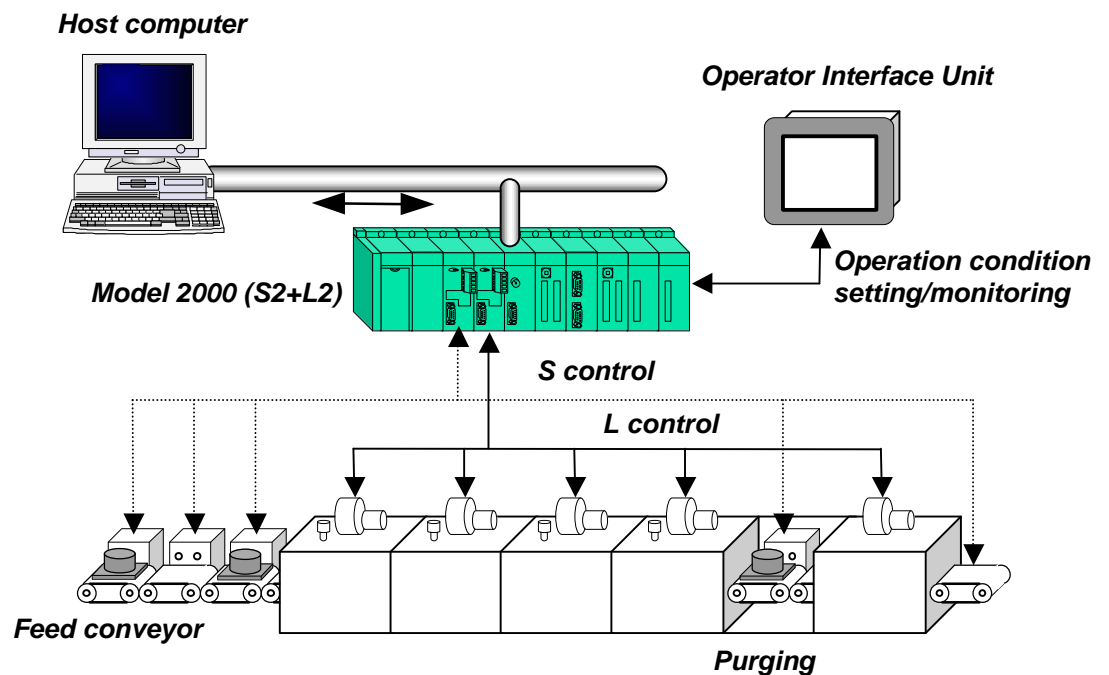
Continuous Annealing Line

◆ System Overview

In the continuous annealing line, the feed speed (conveyor speed), annealing temperature, CO gas density must be controlled depending on the work materials and shapes. Especially precise control of the temperature and the time are important to keep the product quality.

The V-series model 2000 is applied to this system. The L2 controls the temperature and the gas density, and the S2 controls the conveyor speed and the machine sequencing in combination. The operation condition is given by the single operator interface unit connected with the S2.

◆ System Configuration



◆ Features

- (1) Well integration of Process control and Sequence control:
The L module performs advanced loop control.
The S module performs high-speed sequence control.
- (2) Single-point control data management:
The Station Global variables enable the closed combination between the L and the S modules.
- (3) The S module supports the RS485 Computer Link which is compatible with the T-series PLC.