



SIF 405 WORKING INSTRUCTION

**WP5 T5.2.1 TRAINING AND DEMONSTRATION MODULES
DEVELOPED**

Version 1

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1 Power on

1.1 Check

- Remove all product from conveyor
- Remove all product from working space
- Connect tot he compressor
- Put the emergency stop buttons to default position
- Switch off all eletrical switch
- Check the connection with the main power

1.2 Power system

Task



Rotate the power switch to position 1

1.3 Air system

Task



Rotate the station air switch to position sup



After the switch on (approximately 70 seconds) the machine make a self test and calibration. If the station is ready, the HMI show it.



2 Power off

2.1 Deactivate air system

Task



Rotate the main switch to position sup

2.2 Eletrical system switching off

Task



Rotate the eletrical switch to position 0



3 Machine operation

The machine can work manual and automatic mode. In manual mode the machine work standalone, it is not connected to the other machines. In automatic mode the SIFMES software control the entire production line.

3.1 Raw material filling

- The raw material filling only allowed in stopped machine!
- The raw material filling is only possible after the correct lid selection!
- The lids can only placed in the right place and position!

3.2 Lid fill

- Select the STATION COBFIGURATION window on the HMI
- Select the lid type
- Put the lids to the container. Do not fill to the top, keep one lid height from the top!
- Place the lids as the image show
- Push the blue button on the HMI if everithing is correct
- Repeat the process if you have to fill the other lid container



3.3 Manual operation

In manual mode the the choices are:

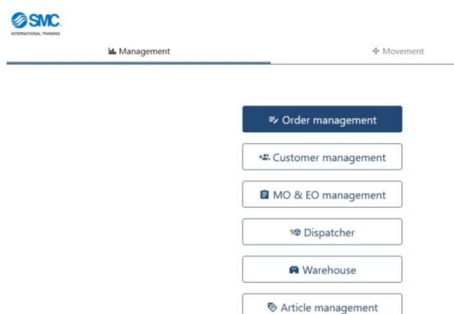
- Square lid
- Round lid

Note, in maual mode select the right lid! Push the start button 2s long to start the process.



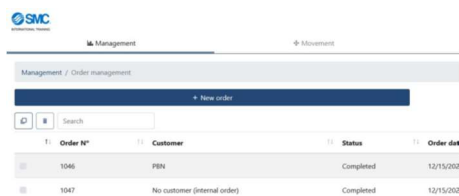
4 SIF Mes

In integrated mode the production line can produce the ordered product. All cell should be switched on, and in resetted state. To order, open the SIFMES software in the browser:



4.1 Order management

In the Management -> Order management we can create a customer order with a New order button. To select the Stock order option the product will go to the warehouse, and will not be assigned with customer. If it is not selected, it will go to delivery.



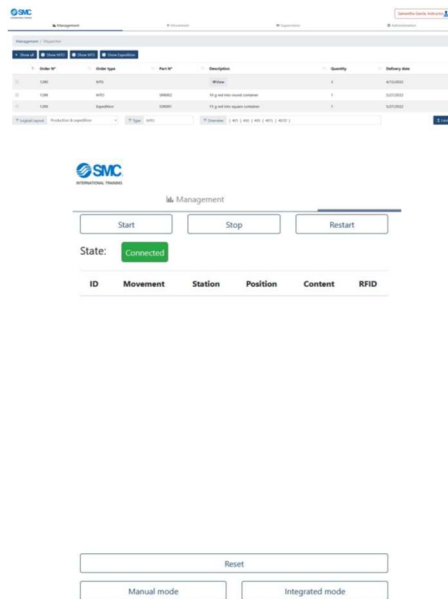
4.2 EO&MO management

In this menu we have two options. The first is a New manufacturing order, where we can produce a previous production order. The second option is the New expedition order, where we can deliver a product from a warehouse. We can choose one of these two options, and below the Order lines we should choose the products and push the Add and the Save button.



4.3 Dispatchet

In the Management -> Dispatcher menu we can start the production. We can choose the mode in the upper part (Show MTO - show the productions for delivery, Show MTS - show the productions for warehouse, Show Expedition - show the delivery for warehouse), then we can choose the lines what we want to produce, and push the Launch button. Then in the Movement - System status menu push the Integrated mode button.



5 Documentation

More information

- Operation Manula SIF-400 Integrated mode
- Operation Manula SIF-400 Manual mode
- Operation Manula SIF-400 Software manual

