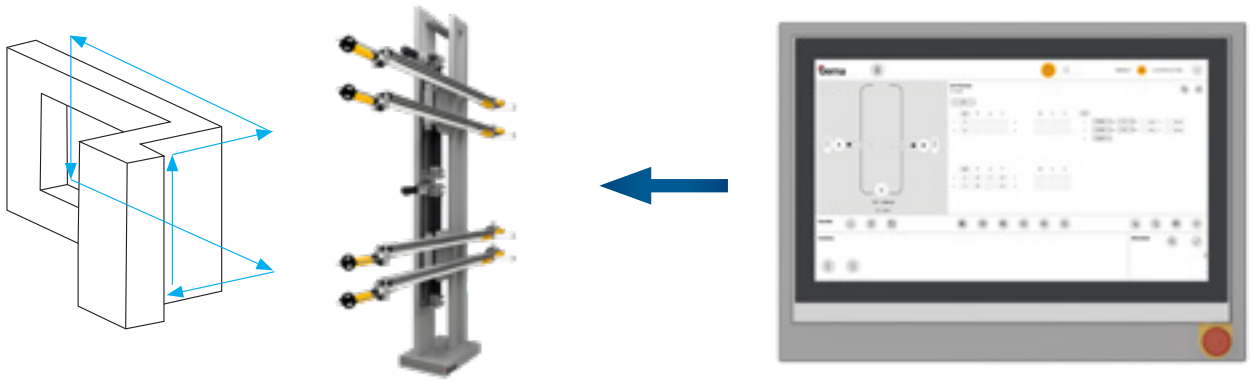
Sequence programming (CM50)

Effortless coating of complex components through intelligent sequential programming

The MagicControl central control unit with the optional Sequence Program enables precise programming and control of individual axis movements or complete station sequences. Complex motion patterns involving X/Y axes, synchronized axes, infeed systems, and rotary axes can be configured and managed directly via the intuitive touchscreen interface.This advanced functionality ensures highly accurate coatings and reproducible results, even for challenging component geometries. It is particularly beneficial for parts with cavities and recessed areas, such as baking molds. During operation, the coating guns automatically follow the inner contours of the component while the conveyor remains in motion, ensuring uniform coverage and consistent quality. The system accommodates suspension tolerances of up to ±6 mm in all three dimensions.



Programming sequential axes movements directly on MagicControl

Functionality of sequence programs:

- The sequence program represents a self-contained motion sequence of an axis or station, which is started by the operator or a higher-level control system. The sequence can take place once, several times or as an endless loop.
- One or more axes of a station can be moved and positioned simultaneously.
- Dependencies of the individual axes movements are programmed with corresponding commands. Such as: Offset commands, waiting times before or during movement, movement start/stop speeds, coating parameter settings, coating start/stop, number of passes
- 16 logical outputs are assigned to each station that are controlled by the sequence program.
- The positioning of an axis can take place in partial steps, between which, for example, other axes are started. The movement is not interrupted.
- In the sequence program the synchronous movement of the station to the conveyor is started and ended.
- Editor for editing a sequence program



1 Sequence program and editor
2 Command overview as a Drop-Down list
3 Editing fields
4 Start button per station in manual mode

User benefits:

- Automatic coating of complex parts or internal coating of hollow bodies such as baking cavaties
- Individual determination of the axes movement
- Coating optimization and influence on layer thickness
- Programing, storage and recall of individual application programs
- Easy to use editor for creating a sequence program

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