

Category: Recommended

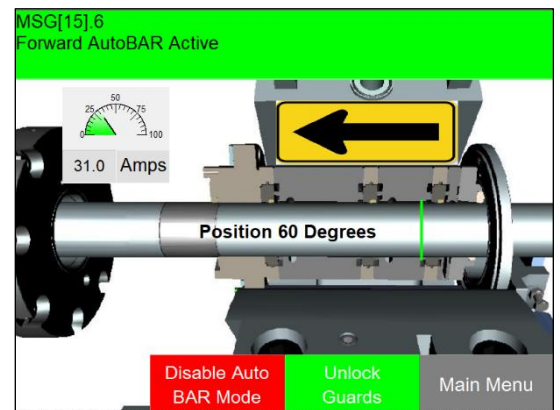
Benefits to Customers:

- One man Bar operation.
- Reduced time to remove wreckage.
- Quicker restart of machine.

Summary: CarnaudMetalbox Engineering Ltd has created the 'AutoBAR™' function within our PLC and Human Machine Interface (HMI) software to enable the Ram to move forwards or backwards automatically without the need to manually use the flywheel barring tool. There are three different functions available with the program. **NOTE:** The function is dependent on the guard doors being locked to ensure operator safety.

AutoBAR™ Mode

- The operator locks the guards and enables the mode via the HMI screen.
- With the guards safely locked, the operator can select the direction of travel and start the motor jogging.
- When the Bar buttons are pressed the clutch is energised and the Ram moves in the selected direction.
- Alarm conditions are continually monitored during AutoBAR™ for **no motion, high motor current, toolpack jam and jog time exceeded.**



AutoBAR™ screenshot

Short Can Assist

- Following a 'short can', misfeed, tear-off or any other unprompted stop, the Bodymaker will automatically dissipate the air from the rear air bags.
- The PLC program will decide forward or reverse motion depending on the stopped position of the ram.
- The machine automatically positions the Bodymaker redraw carriage fully retracted and the end of the punch sleeve flush with the redraw sleeve. This enables the operator maximum access for clearing misfeed and other metal forming errors.

Start Position Assist

- Auto function following a clear out.
- Ram automatically moves forward, or reverse, to the ideal restart position.

For further information regarding this Technical Bulletin, please contact either of the contacts below quoting Technical Bulletin number **TB5000-088** and your machine Serial Number. A complete library of Technical Bulletins is available on the company web site.

