

dametric

GMS – AGS – SB170

AGS / SB-170

Disc GAP [mm]	1.37	
Alarm status OK	Disc. Temperature DTM [°C]	29
	Touch Point TVD [%]	0
	Rotor position POM [mm]	1.25
	AGS Position APO [mm]	0.00

MENU **?** Auth.: None dametric 

GMS CE Panel-PC

Manual

Table of contents

1	OVERVIEW	3
2	SECURITY	3
3	NORMAL VIEW	4
4	PROGRAM FUNCTIONS.....	4
4.1	Menybild	4
4.2	AGS Service.....	5
	AGS Auto Calibrate	5
	Coarse Calibrate	6
	Tip Replacement	6
	Holder Exchange.....	6
	Adjust flush position	6
4.3	Service	7
	DCA – Disc Clearance Amp.....	7
	DTM – Disc Temp. Monitor	7
	APO – AGS Position	8
	APO - Advanced	8
	APO Adjust.....	8
	TVD / TED – Touchpoint Detector	9
	POM	9
5	PARAMETERS	10
6	SYSTEM SETTINGS.....	10
	Login	10
	System Tab	10
	IO Tab	11
	AGS Tab	11
7	CALIBRATION LOG	12
8	ALARM LOG.....	12
9	TREND	12
	Trend settings	13
10	SELECT CEC UNIT.....	13
11	ABBREVIATIONS	14
12	CONTACT	14

1 Overview

The GmsCE program shows signals and parameters from units in the measurement system for measurement and control of the AGS sensor in a pulp refiner. An AGS sensor consists of a Disc Clearance sensor (TDC sensor), vibration sensor and a measure- and adjustment mechanism for moving of the measurement tip relative to stator segments. The purpose with an AGS sensor is to increase the measuring accuracy, simplify the calibration procedure and make it possible to do so during production without interfering with the process. Recurring calibrations of the sensor is necessary after a certain operation time due to the wear of the sensor and the segments.

This system is designed for the Andritz SB170 and Twin-66 refiners.

The program consists of steering logic for accomplishing an automatic calibration of the AGS sensor. The program is a GUI application which consists of buttons and text boxes and all commands are triggered through pressing of buttons on the touch screen.

The operator navigates from a normal top view window down through the program structure according to the menu choices that are presented to finally reach the searched function.

The Program runs on a Panel-PC which is based on the Windows CE 6.0 TM operating system from Microsoft.

The program GMS CE is included in a measurement system which is called GMS, Gap Measuring System, which communicates with some of the modules in the RMS system.

The DCM-DM1 (Disc Clearance Monitor), is a measurement module for the plate gap and the gap temperature. See the DCM-DM1 manual for more information.

The ACM-DM1 (AGS Control Module) communicates with the AGS sensor head which measures the touch point vibration (TVD), the position of the measuring tip (APO) and also controls the movement of the tip by a stepping motor. ACM also include digital in- and outputs for communication with the PLC/DCS. See the ACM-DM1 manual for more information.

The units use a CAN-bus to communicate between each other. The Panel-PC uses UDP (IP based protocol) to communicate with the hardware units through a CEC-DM1, a CAN Ethernet converter module. The outputs from the system consist of analogue isolated current signals and changing relay contacts. See the abbreviation chapter at the end of this document for descriptions for the abbreviations in the text.

2 Security

It can be pointed out that all security regarding the measurement signals and logic are as before placed in the measurement modules which are suited for its purpose. The Panel PC and its software have as its task to show measured values, alter parameters and to provide sequences for example AGS calibration. This means that the Panel PC can be closed off without that no measure signals fail to come or get changed which would affect the refiner mode of operation.

3 Normal View

In the normal view, the plate gap, the rotor position, the plate gap temperature, the touch point, the refiner vibration, the motor power, A- and B-chamber pressures, the oil temperatures, the gap controller set point and the AGS position.

MENU By pressing the MENU button the other program functions can be reached, e.g. calibration of the AGS sensor.

? By first pressing the "?" and then one measure value or button a help text is shown. Under "System Settings" other languages can be selected for the help texts.

Show alarms This button is shown only if an alarm is active and displays the alarms in a separate window.

AGS / SB-170	
Disc GAP [mm]	1.37
Alarm status	OK
Disc. Temperature DTM [°C]	29
Touch Point TVD [%]	0
Rotor position POM [mm]	1.25
AGS Position APO [mm]	0.00
MENU ? Auth.: None dametric	

4 Program Functions

The program functions are divided into the following main groups.

4.1 Menu

AGS Service This function includes services for the auto calibration of the AGS sensors and for to change the measuring tip.

Service The functions in the Service menu are for altering parameters and to be able to calibrate the system's measurement functions. The program gives you a overview over the functions and what settings possibilities there are for each function.

All settings and adjustments are stored in a permanent memory for respective measurement module. The parameter settings that are under the Service menu are placed in a table format for respective function for fast and simple handling.

Trend The Trend tool shows a trend over the most common signals in the system.

System Settings In this part are settings that control the GMS-CE program logic. E.g every measurement system can be given a suffix to make it easier of the identification when double measurement system is used. The settings can be stored in a file on an external memory (Compact Flash) connected to the Panel PC.

Calibration Log Performed calibrations are stored to make it easier to do service and diagnostics when something unpredicted occur. These logs can be read by this function.

Alarm Log Possible alarms are stored to make it easier to do service and diagnostics when something unpredicted occur. These logs can be read by this function.

Cons Evaluate This function is used to evaluate the impedance measurement between the tip and the rotor. This is showed only if the measurement is enabled.

Login/Logout Use the Login (or Logout depending of the login status) makes it possible to login to the different authorization levels which give more or less access to the different settings and functions within the system. The available levels are "None", "Operator", "Service" and "Administrator".

Menu	
AGS Service	System Settings
Service	Calibration Log
Trend	Alarm Log
Cons Evaluate	
Close Login 2010-02-16 12:34:42 About	

4.2 AGS Service

In this menu the following functions can be reached:

Auto Calibrate

The AGS sensors must be calibrated when they are mounted in the refiner and running in production mode to achieve an accurate plate gap. The calibration sequence is described in a separate document. The user must be logged in as operator.

Coarse Calibrate

The coarse calibration is done automatically when a tip has been replaced.

Tip Replacement

The function for a tip replacement is reached here.

Holder Exchange

Use this function to exchange the holder or the AGS house.

Adjust Flush pos.

This function is used to position the measuring tip flush with the stator plates and are used when the tip has been replaced.

Show alarms

The actual alarms are displayed.

Parameters

Edit the calibration parameters.

Information

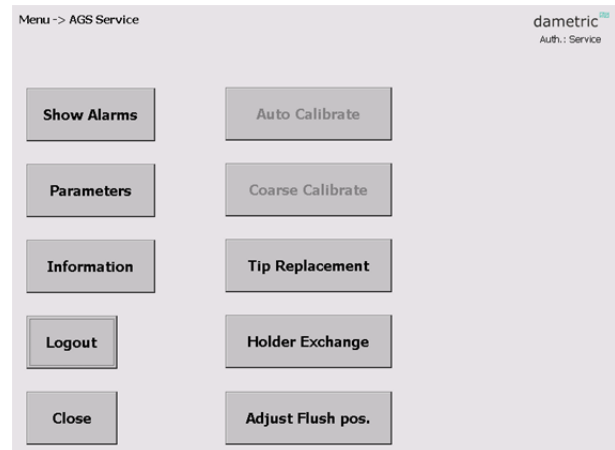
Press for information of the buttons in this window.

Login/Logout

Login (or Logout depending of the login status) to access protected parameters and functions.

The user must be logged in as operator to be able to use the *Auto Calibrate* function.

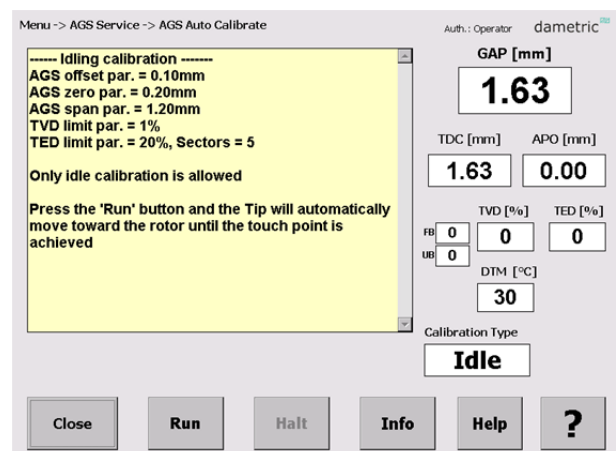
The *Coarse Calibrate*, *Tip Replacement*, *Holder Exchange*, *Adjust Flush pos* and *Parameters* functions are available first when you have logged in using the service code. The *Coarse Calibrate* button is disabled after the sensor is calibrated to prevent the calibration to be destroyed unintentionally.



AGS Auto Calibrate

Here you can calibrate the AGS sensors which are done with automation.

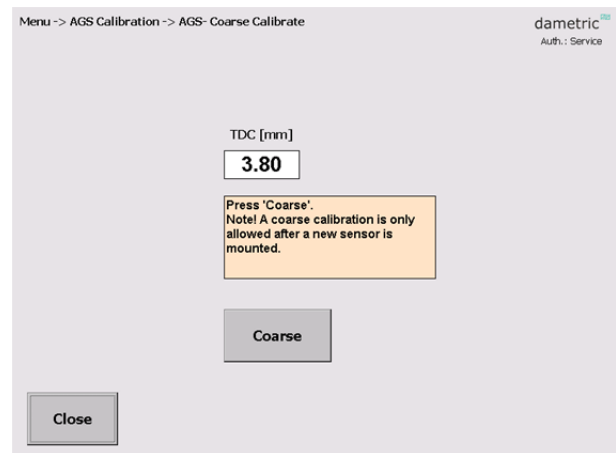
Consult the “GmsCeAgs-Calibration_Eng.pdf” for details.



Coarse Calibrate

Coarse calibration is performed when a new tip is mounted.

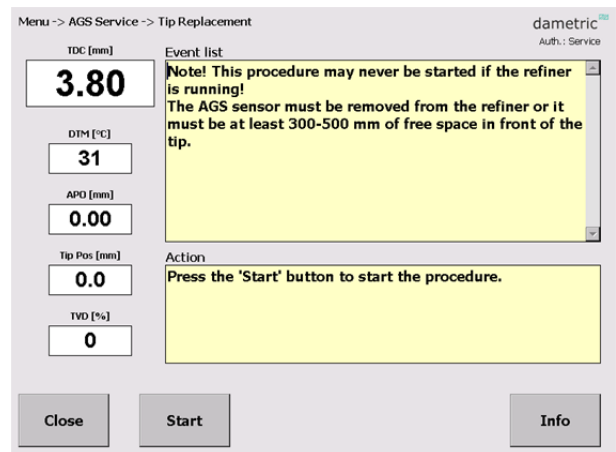
Consult the “GmsCeAgs-Calibration_Eng.pdf” for details.



Tip Replacement

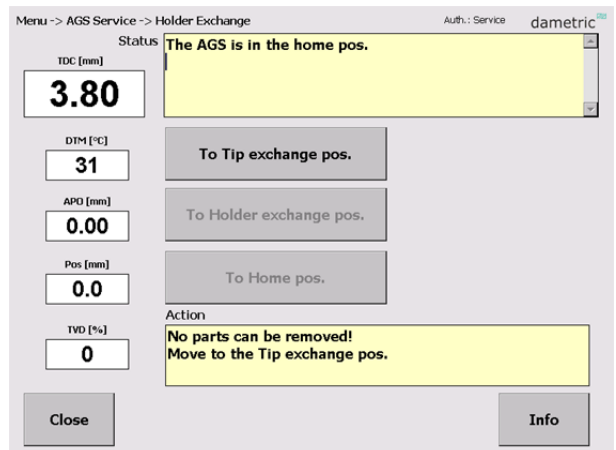
When the tip is worn out you use this sequence driven function to change to a new tip.

Consult the “AGS-XXX-ServiceManual_Eng.pdf” for details.



Holder Exchange

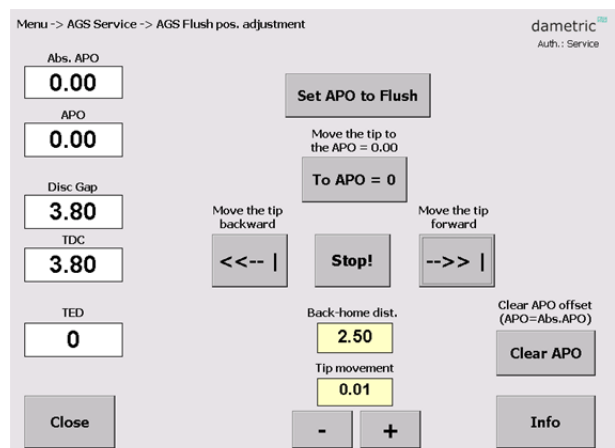
This procedure is used to replace the holder or the head of the AGS sensor. Consult the “AGS-XXX-ServiceManual_Eng.pdf” for details.



Adjust flush position

Use this procedure to align the measuring tip toward the stator plates.

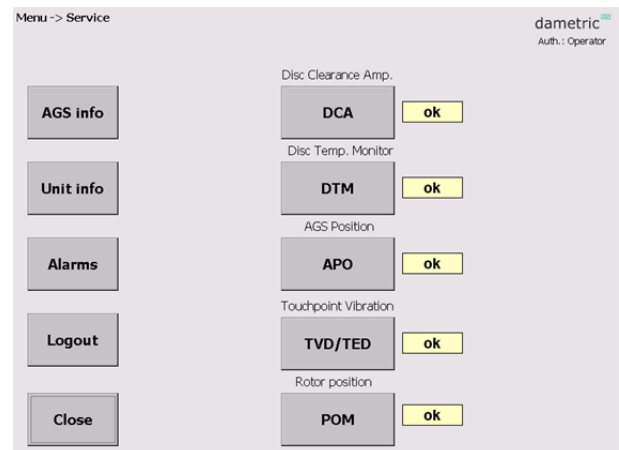
Consult the “AGS-XXX-ServiceManual_Eng.pdf” for details.



4.3 Service

The Service menu shows the measuring functions of the GMS/RMS-system.

By pressing on one of the measurement functions, the underlying parameters and calibration can be reached. Some of the functions, e.g. the calibrations, are protected against unintentional harm to the system and can be done only after that the login code has been entered.



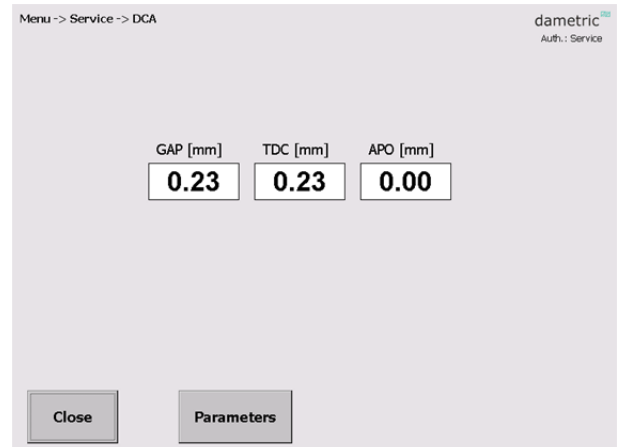
DCA – Disc Clearance Amp.

Parameters (logged in as service)

Here you can alter parameters that belong to the DCA measurement function.

System (logged in as administrator)

Here you can alter hardware related parameters that belong to the DCA measurement function.



DTM – Disc Temp. Monitor

Span Cal (logged in as service)

Function for span calibration.

Zero Cal (logged in as service)

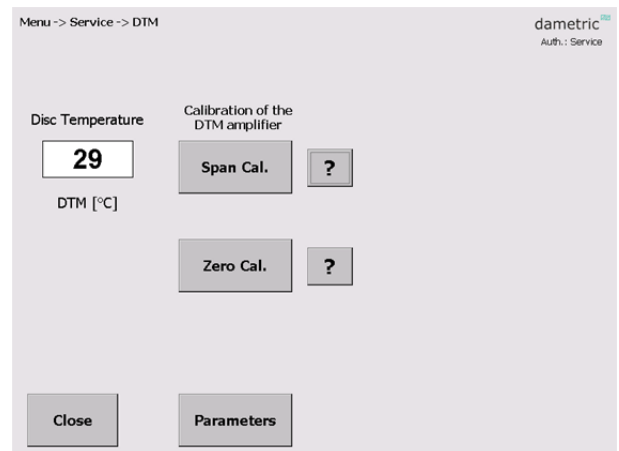
Function for zero calibration.

? (logged in as service)

A help text for the calibration sequence is presented on the screen.

Parameters (logged in as service)

Here you can alter parameters that belong to the DCA measurement function



APO – AGS Position

The AGS position and the absolute position of the dip are shown together with the actual temperature inside the AGS head. The temperature should be below 70°C (160°F) to maintain expected life time of the AGS head.

Parameters (logged in as service)

Here you can alter parameters that belong to the APO measurement function.

System (logged in as administrator)

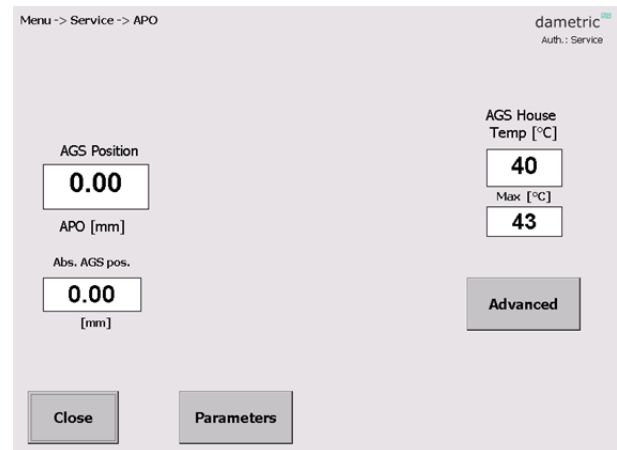
Here you can alter hardware related parameters that belong to the DCA measurement function.

Advanced Functions (logged in as service)

This function makes it possible to manually move the tip which is used for maintenance/development of the measurement system.

Move to home (this button is only showed if the APO is not close to zero)

The tip can be moved to the home position (APO=0.00) by pushing the button. Note that there will be a corresponding change in the gap value.

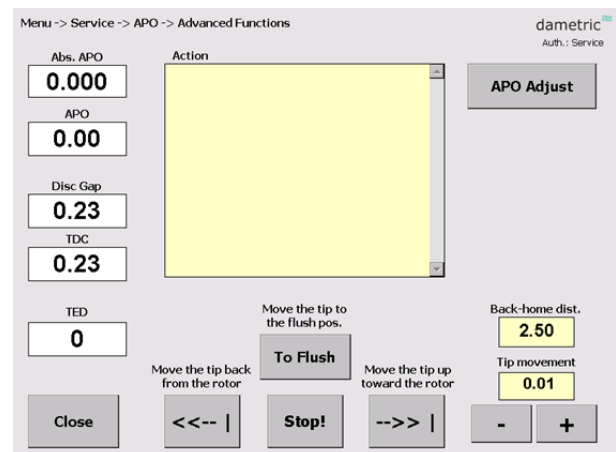


APO - Advanced

APO Adjust

With this command the positioning system of the AGS sensor is calibrated against the amplifier inside the AGS sensor. This is done by moving backwards towards a mechanical stop which is normally 2.50 mm behind the sensors home position (in level with the stator segment) and then move forward the same distance.

- First control that the distance (Back-home-distance) is set ok.
- Press the 'APO Adjust' button and the adjustment sequence starts (this can be monitored in the text window).
- Check that the distance between the tip edge and support edge is 23.00 (+0/-0.05) mm.



If logged in as administrator:

APO Calibrate The operator can calibrate the APO measurement circuit. Note that the sensor tip must not be mounted during this calibration.

To Flush Command for moving the tip to the home position.

<<--| Command for moving the tip a chosen distance apart from the rotor.

-->>| Command for moving the tip a chosen distance towards the rotor.

Stop! Stop the movement.

+/- Chose a distance between 0.01 and 1.00 mm.

TVD / TED – Touchpoint Detector

In this menu there are functions for measurement of the touch point signal. The parameters for limits and sensitivity can be edited.

TVD (Touchpoint Vibration Detector) measures the vibration caused when the tip hits the rotor while the TED (Touchpoint Electric Detection) measures the resistance between the tip and the rotor. The TED signals are only displayed if the TED function is enabled.

TVD-signals (logged in as service)

The settings and results are displayed.

TED Graph (logged in as service)

A graph with values divided in 12 sectors of the rotor is displayed if the TED function is enabled.

Move tip (logged in as administrator)

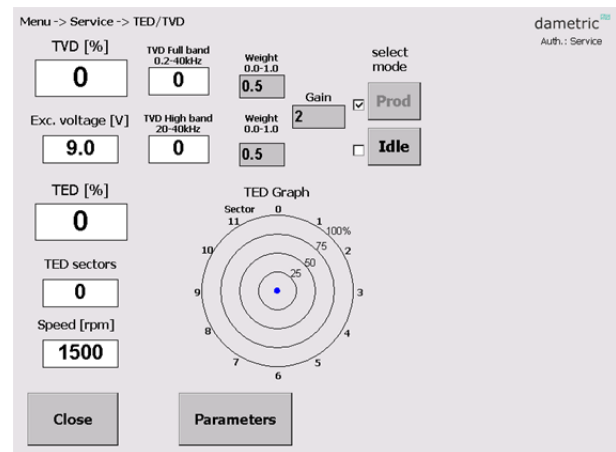
A number of functions is shown to move the tip to be able to investigate how the tip position will affect the TVD and TED measurement.

Parameters (logged in as service)

Here you can alter parameters that belong to the TVD and the TED measurement functions.

System (logged in as administrator)

Here you can alter hardware related parameters that belong to the TVD measurement function.



POM

The value of the external current signal which reflects the rotor position is shown here.

Span Cal. (logged in as service)

Calibration of the input current at 20.00mA. This function requires an external current generator.

Zero Cal. (logged in as service)

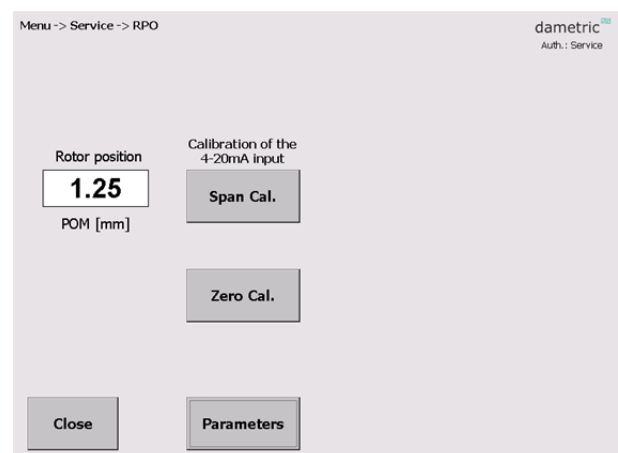
Calibration of the input current at 0.00mA. This function requires an external current generator.

Parameters (logged in as service)

Here you can alter parameters that belong to the measurement.

System (logged in as administrator)

Here you can alter hardware related parameters that belong to the measurement.



5 Parameters

This is an example of the parameters for the DCA function is shown. Every parameter is shown with a short description and the allowed max- and min values. Furthermore, the node from where the parameter belongs to is also shown. There is also a possibility to copy the parameter settings to a XML file for printing or archiving. As the list can be rather long, the parameters from respective node can easily be unselected from the list by a single press on a button.

Select a parameter in the table by tapping the text and a descriptive text will appear. Press 'Edit' to edit the selected parameter.

Parameter	Node	Value
DCA - Production gap (max) limit	1	1.00
TDC - Analogue output offset	1	0.00
TDC - Analogue output range	1	3.00
TDC - Coarse cal. interlocking	1	0.00
TDC - Filter	1	2.0
TDC - Limit value -	1	0.60
TDC - Limit value ++	1	0.30
TDC - Limit value +	1	1.00
TDC - Limit value ++	1	1.30
TDC - Refiner RPM	1	1500

Close Edit

To alter a parameter, do like this:

- Select the parameter by marking its name (a description of the parameter is shown at the top of the screen).
- Press the **EDIT** button and a new window with a key pad is shown.
- Enter the new value by using the key pad on the screen.
- Press the **SAVE** button. The program will give a warning if the entered value is outside its allowed range.

The parameter values are stored into a XML file when the **Save to file** button is pressed.

6 System settings

Some of the functions are protected with a password and are thereby not available when one doesn't have the right authorization.

Login

The login makes it possible to login to different authorization levels which give more or less access to the different settings and functions within the system.

System Tab

Service info

Address, phone and email contact data for service and maintenance.

Help text language

Select language for the help texts.

Refiner ID

Defines a unique id for the installation which is used when transferring files to the external memory stick. This makes it possible to handle several installations. Press the 'Edit Refiner ID' button to change the id.

Regenerate

Use this button read new parameters from the hardware units. This is only used if the hardware is updated or changed and new signals have been added. The parameters are stored in a XML-file which is used each time the program is started.

Log AGS cal.

When this function is activated, the measure data regarding the AGS calibration are logged.

Menu -> System settings Auth.: Service dametric

System IO AGS

Service info Help text Language English Refiner ID R1 Edit Refiner ID

Parameter file Regenerate

Close Logout

IO Tab

CEC Serial no. / Select CEC

Function for selecting the CEC-DM1 unit.

File Browser

Function for copying of XML and log files to a USB stick.

Touch panel cal.

Calibrate the touch screen, press the button and follow the instructions.

The screenshot shows the 'IO' tab selected in the 'System settings' menu. The interface includes a header with 'Merry -> System settings' and 'Auth.: Service dametric'. Below the header are three tabs: 'System', 'IO', and 'AGS'. The 'IO' tab is active, displaying four buttons: 'CEC Serial no.' (with a text input field containing '1059'), 'Select CEC', 'File Browser', and 'Touch panel cal.'. At the bottom of the screen are 'Close' and 'Logout' buttons.

AGS Tab

AGS 1 Suffix

Set a suffix for each AGS sensor depending on the location in the refiner. E.g. "C" for a sensor in the CD zone. This will not affect the functionality but it is only used in the notation of the presented measurement signals and logged functions.

AGS sensor type

Select the sensor used in this refiner.

AGS "1"

The actual service dates and the current operation hours are shown.

The screenshot shows the 'AGS' tab selected in the 'System settings' menu. The interface includes a header with 'Merry -> System settings' and 'Auth.: Service dametric'. Below the header are three tabs: 'System', 'IO', and 'AGS'. The 'AGS' tab is active, displaying several fields: 'AGS '1' suffix' (a dropdown menu with '1' selected), 'AGS '1' sensor type' (a dropdown menu with 'AGS-SB170' selected), 'AGS '1'' (a text input field), 'Last service' (a date field with '2010-02-16'), 'Next service' (a date field with '2011-02-16'), 'Tip ser. no.' (a text input field with '0029'), 'Tip tot hours' (a text input field with '41'), and 'Tip prod. h.' (a text input field with '0'). At the bottom of the screen are 'Close' and 'Logout' buttons.

7 Calibration log

In the calibration log calibration events can be shown.

Menu -> Calibrate Log		dametric
		Auth.: Service
2010/02/16 9:45:43	AGS calibration accepted (prod.)	
2010/02/16 9:45:35	TED sector data S0.11=12,25,20,13,9,2,2,16,23,24,20,24%, Ave.=15 (Lim.=20)	
2010/02/16 9:45:28	Span point at TDC=1.09mm, APO=-0.98mm, POM=1.25mm	
2010/02/16 9:45:19	TVD Touch, TVD=2%, TED=15%, TDC=0.09mm, APO=0.05mm, POM=1.25mm	
2010/02/16 9:45:15	AGS calibration started (prod.), Gap=0.13mm, Zero=0.10mm, Span=1.10mm	
2010/02/16 9:44:59	AGS calibration accepted (prod.)	
2010/02/16 9:44:56	TED sector data S0.11=25,20,27,33,22,15,0,6,0,4,10,25%, Ave.=15 (Lim.=20)9	
2010/02/16 9:44:50	Span point at TDC=1.10mm, APO=-0.72mm, POM=1.25mm	
2010/02/16 9:44:41	TED Touch, TED=15%, TED Quality=3, TVD=1%, TDC=0.10mm, APO=0.31mm	
2010/02/16 9:44:27	AGS calibration started (prod.), Gap=0.39mm, Zero=0.10mm, Span=1.10mm	
2010/02/16 9:44:21	AGS calibration accepted (prod.)	
2010/02/16 9:44:08	TED sector data S0.11=4,23,23,21,26,29,34,20,5,1,0,2%, Ave.=15 (Lim.=20)%	
2010/02/16 9:44:03	Span point at TDC=1.18mm, APO=-0.72mm, POM=1.25mm	
2010/02/16 9:43:53	TED Touch, TED=15%, TED Quality=3, TVD=1%, TDC=0.18mm, APO=0.31mm	
2010/02/16 9:43:43	AGS calibration started (prod.), Gap=0.49mm, Zero=0.10mm, Span=1.10mm	
2010/02/16 9:42:56	AGS calibration accepted (idle)	

Close Refresh Home Up Down

8 Alarm log

To make it easier for trouble shooting all alarms that have occurred are listed here.

Menu -> Alarm Log		dametric
		Auth.: Service
2010/02/16 11:32:08	AGS Unit on line	
2010/02/16 11:32:08	ACM Unit sum alarm cleared	
2010/02/16 11:32:05	AGS Unit off line	
2010/02/16 11:32:05	ACM Unit sum alarm set	

Close Refresh Home Up Down

9 Trend

A trend picture shows, the plate gap, the touch point and the rotor position/hydraulic pressure.

Time Scale

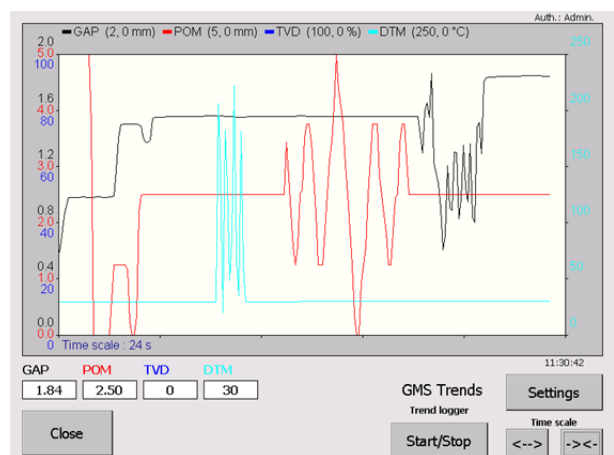
Press the Time Scale button to change between three different time scales, ca 7 – 14 – 66 s.

Settings

Use this function to set the scale ranges and the offsets.

Trend Logger

It is possible to log the values to a log file. The function is started and stopped with the **Start/Stop** button.



Trend settings

Parameter Up/Down

Use the Up/Down buttons to scroll selected parameter in the parameter list. Selected parameter is shown with the Parameter and Unit boxes.

Range, Up/Down

Step between five pre-set ranges for the actual parameter.

Offset, Up/Down

Increase/decrease the offset with a pre-set value.

Center

Press the Center button to adjust the offset so that the measure value comes in the middle of the scale.

10 Select CEC unit

The Panel-PC must establish a network connection with the CEC-DM1 unit. The CEC (Can to Ethernet Converter) is the interface between the Ethernet (UDP) on the Panel-PC and the CAN bus from the hardware units.

The CEC selection is stored in an XML-file in the computer and is read automatically when the system starts. The connection has to be manually done if the computer or the CEC is changed.

- Press 'Menu' and log in as Service.
- Press the 'System Settings' button, select the 'IO' tab.
- Press the 'Select CEC' button.
- Press the 'Search' button. At least one CEC unit should be shown. If more than one CEC, check the serial number for identification.
- Tap the CEC unit in use and then press the 'Select' button. The Status should then read "Connected".
- Press 'Close'.

11 Abbreviations

CE TM. Operating system from Microsoft.

UDP – User Datagram Protocol. A connection less protocol for transferring of individual packets over IP.

TDC - True Disc Clearance. Plate gap measured with a sensor placed in level with the stator segment.

AGS - Adjustable Gap Sensor. A TDC sensor with moveable tip which can be moved forward and backwards for calibration.

GMS – Gap Monitoring System. A measurement system for measure and presentation of the signals in a refiner, e.g. the plate gap and plate gap temperature.

DTM – Disc Temperature Monitor. The plate gap temperature measured inside in the plate gap with a TDC- or AGS sensor.

TVD – Touch point Vibration Detector. A measure on the touch point signal between the disc plates based on the vibration. The signal is used to define the zero position (plate gap = 0) and is the basis of the zero calibration of a TDC- or AGS sensor.

TED – Touch point Electric Detector. The electrical touch point signal between the disc plates. The signal is used to define the zero position (plate gap = 0) and is the basis of the zero calibration of a TDC- or AGS sensor.

APO – AGS Position. A signal for the position of the tip in a AGS sensor. It is zero when the tip is in level with the stator segment. The signal is increased when the tip is moved towards the rotor and decreased when it is behind the segment edge.

RPO – Rotor Position. A signal for the rotor axial position. (for LC refiners).

DCM – Disc Clearance Module. Measurement module for the plate gap and plate gap temperature.

DCA – Disc Clearance Amplifier. Measurement module for the plate gap and plate gap temperature.

ACM – AGS Control Module. Acts as a link between the AGS and the CAN-interface.

CAN – Control Area Network. CAN is a standard field bus.

CEC - CAN to Ethernet Converter. A unit than converts the Ethernet data to the CAN-bus connecting the RMS units.

12 Contact

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