



SIMATIC Technology

Technological tasks with SIMATIC



作者介绍



者简介

ATIC Technology 纵览

357-2

M357-2 Feature

M357-2 Application

U31xT-2DP

PU31xT-2DP Branches

Technology Data

rofibus DP (Drive)

terface Module

PU31xT-2DP Feature

PU31xT-2DP Application

ernet

SIEMENS



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高速计数和测量功能

- ▣ 连续计数、单次计数、周期计数
- ▣ 频率、速度、周期测量
- ▣ 比例器
- ▣ 适用范围非常宽泛

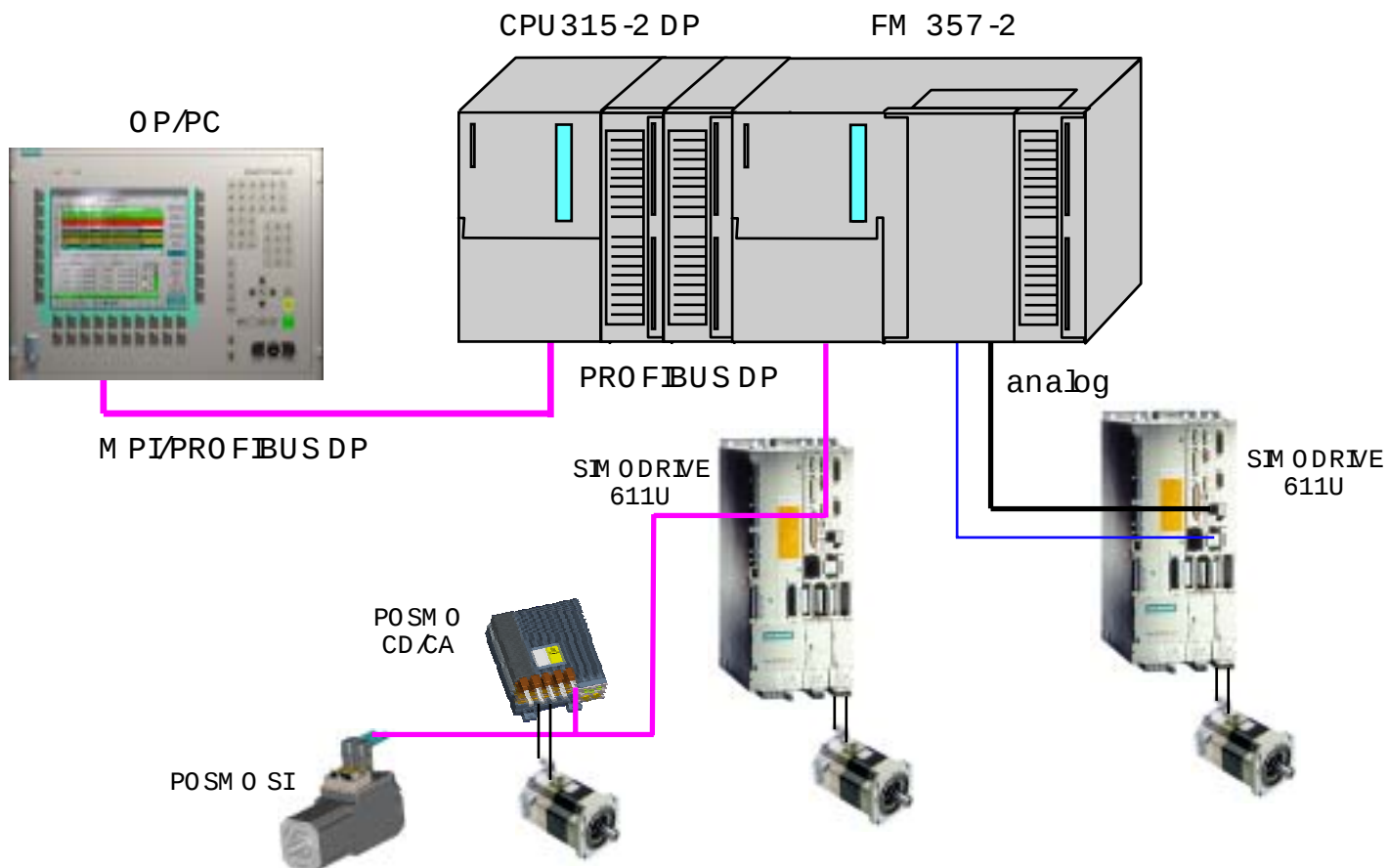
闭环控制

定位控制

- 快速接近、爬行进给定位
- 1/2/3/4轴直线插补，独立定位
- 2轴圆弧插补连续路径控制
- 独立轴之间的位置同步控制

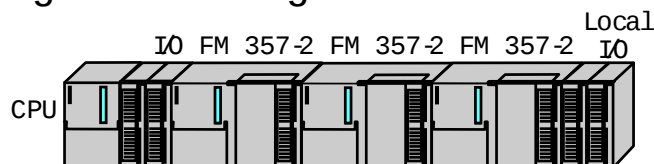
- 位置触发凸轮输出信号
- 时间触发凸轮输出信号
- 适用于印刷、包装机，等等

凸轮控制

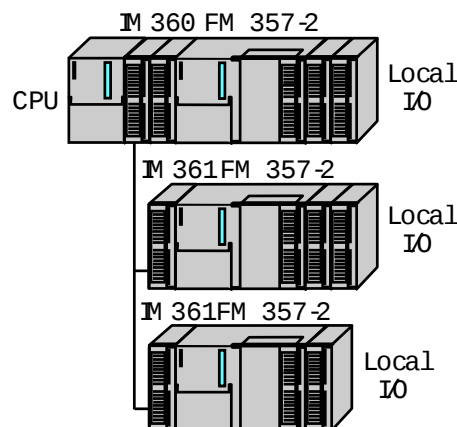


FM357-2 模块系统配置图

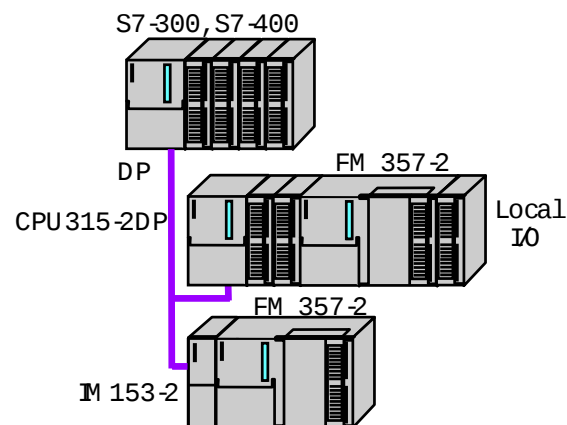
Single-tier configuration



Multi-tier configuration



Distributed configuration



Operation with an M 153-2 should only be used with low performance requirements!

- Max. 3 FM 357-2 per CPU (max. 1 FM with Firmware version H)
- Central or distributed configuration
- Local bus segment with up to 2 I/O modules for fast reaction (on right side of FM only!)



FM357-2 模块订货号



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Internet

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■ FM 357-2 Hardware

6ES7357-4AH01-0AE0

■ FM 357-2 L System firmware

6ES7357-4AH03-3AE0

00 00000 0 00 000 0000 * + 000 000 0 00000 0 0000000 0

■ FM 357-2 LX System firmware

6ES7357-4BH03-3AE0

00 00000 0 00 000 0000 * + 000 000 0 00000 0 0000000 0

■ FM 357-2 H System firmware

6ES7357-4CH03-3AE0

00 00000 0 00 000 0000 * + 000 000 0 00000 0 0000000 0

0 0 000 0 00000 0 0000000 (0 000 00 ,000 000 ,000 000 ,000 000)
00 00000 0 00000 0 000000000 0 0000 ,0000000 0 0 00000 0 0000000 ,
00 -00000000000 000000 ,0 0 -00000 000 0 0000

■ Printed Manual

6ES7357-4AH00-8?G0

(0 000 0000 ,000 00000 ,00000000 ,000 00000)

■ Edit-FM Program editor (stand-alone)

6FC5263-0AA03-0AB0

(00 00000 00000 0000 /000 ,00 0000 0000 00 000 -2)

* 0000 00000000 ,0000 0000 000000 -0000000 000000000 000 0 00000000 000
0 00000 000000000 0 00000000 /00



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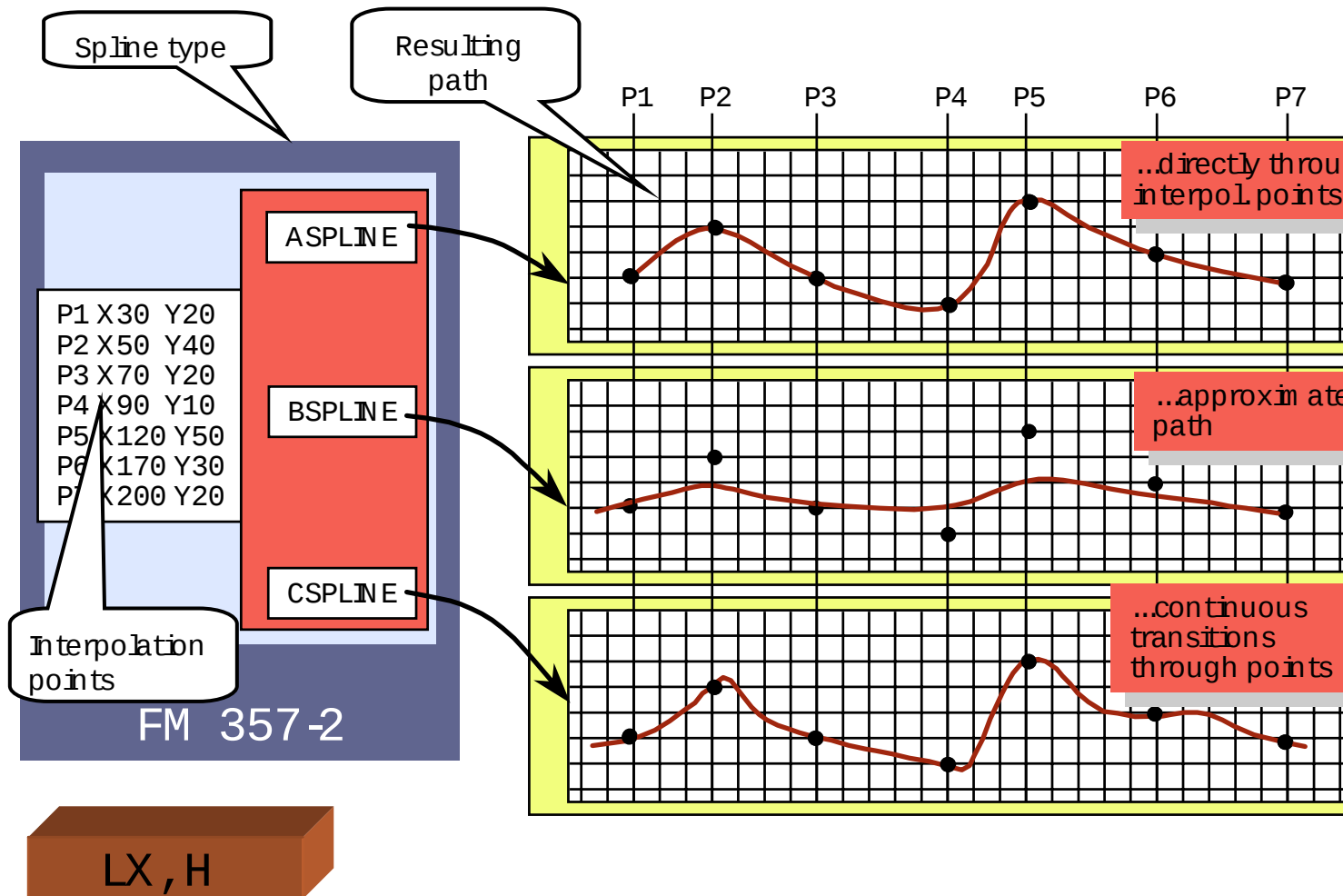
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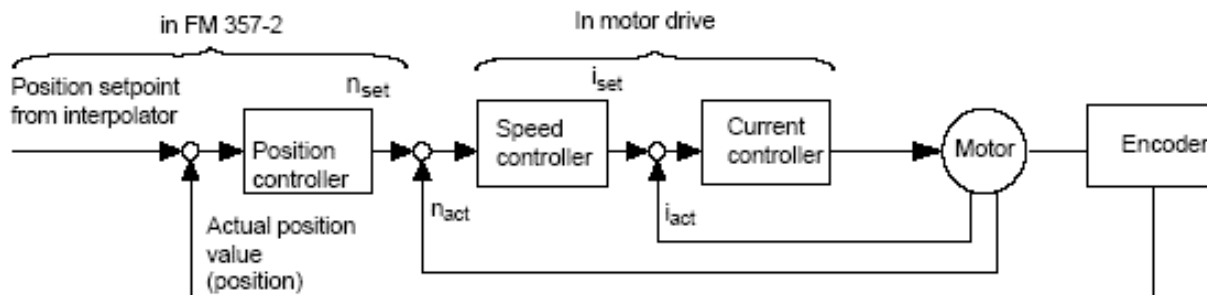
FM357-2 Spline 插补算法



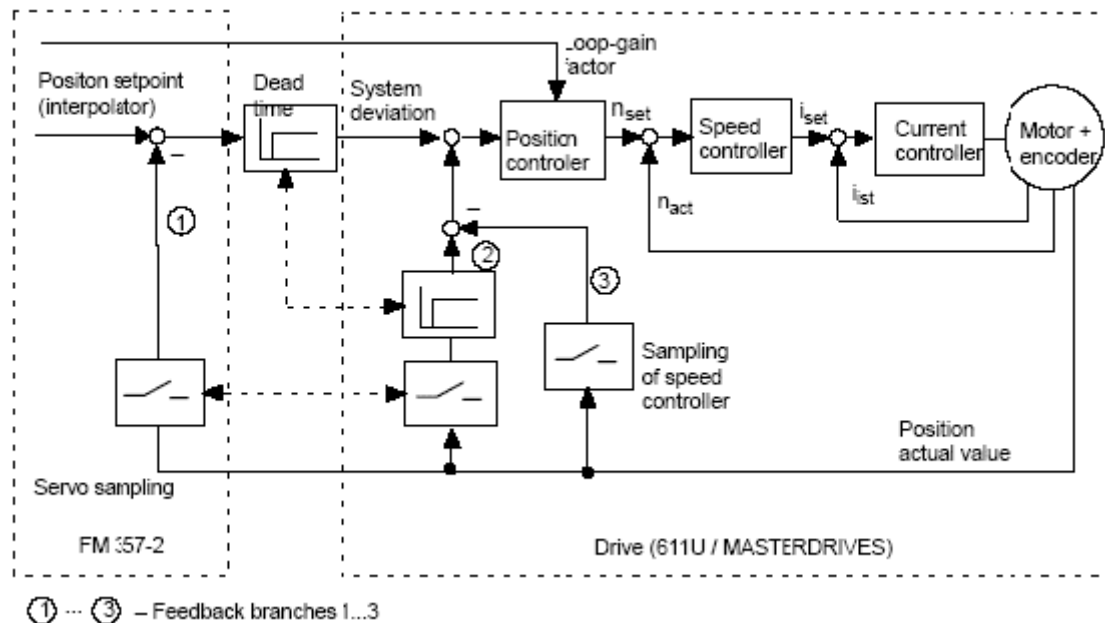
使用几个给定点，完成复杂的连续路径控制



FM357-2 DSC (Dynamic Servo Control) 功能(1)



传统、常规的位置控制循环原理



DSC位置控制循环原理

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FM357-2 DSC (Dynamic Servo Control) 功能(2)

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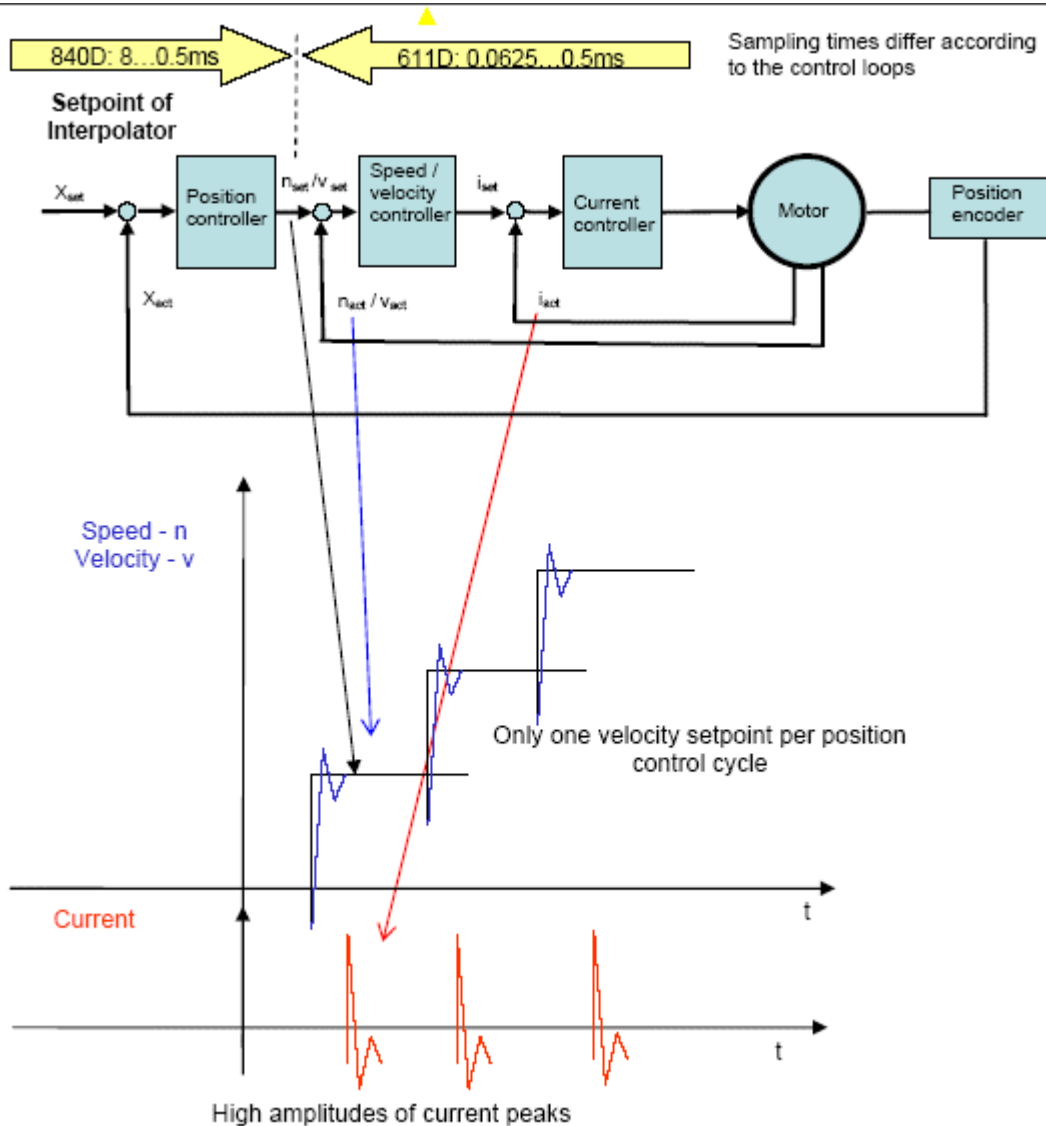
Profibus DP (Drive)

Interface Module

CPU31xT-2DP Feature

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传统、常规的位置控制循环原理的缺点



FM357-2 DSC (Dynamic Servo Control) 功能(3)

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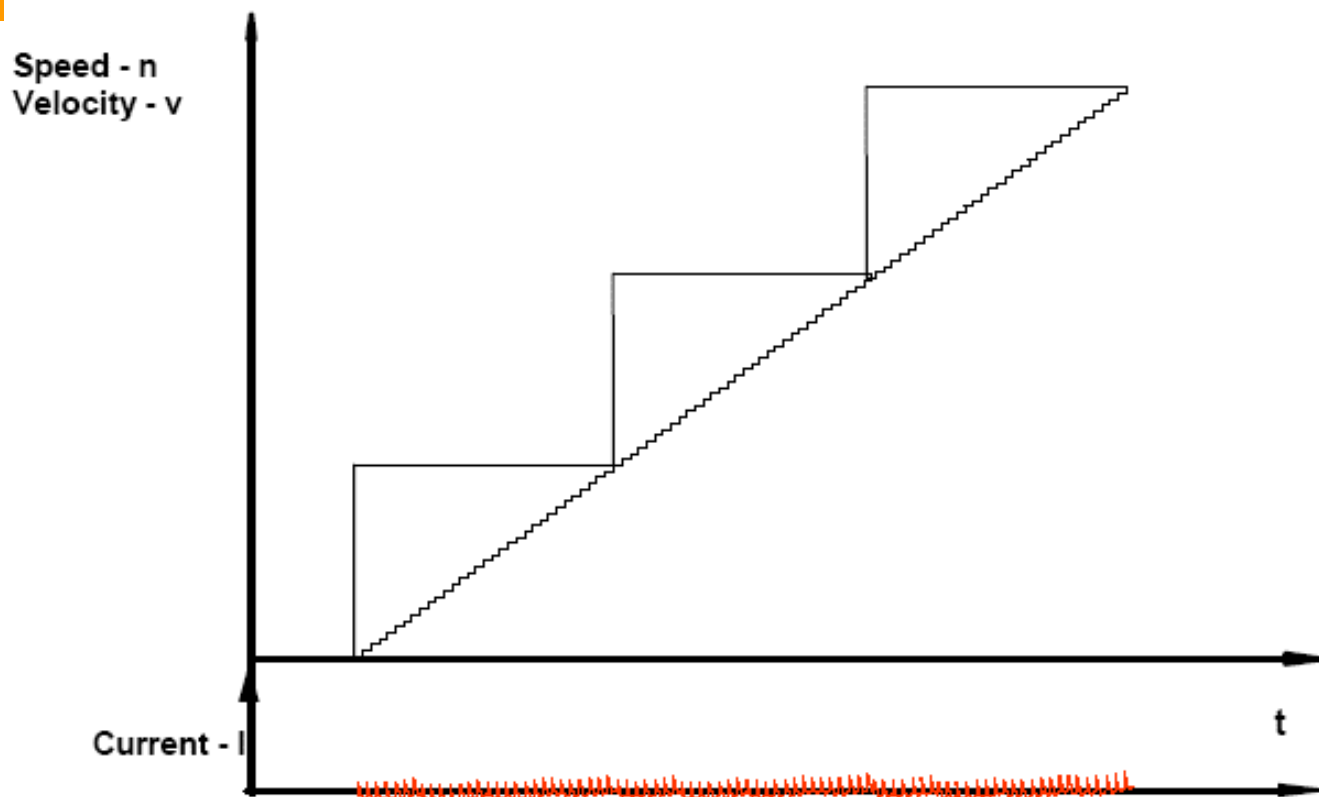
PU31xT-2DP Feature

PU31xT-2DP Applic

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Fine interpolator, functional example
PM1004.12 = 1 (or DSC)
Interpolation of the speed setpoint in the speed control cycle



DSC的位置控制循环原理优点



FM357-2 路径的速度



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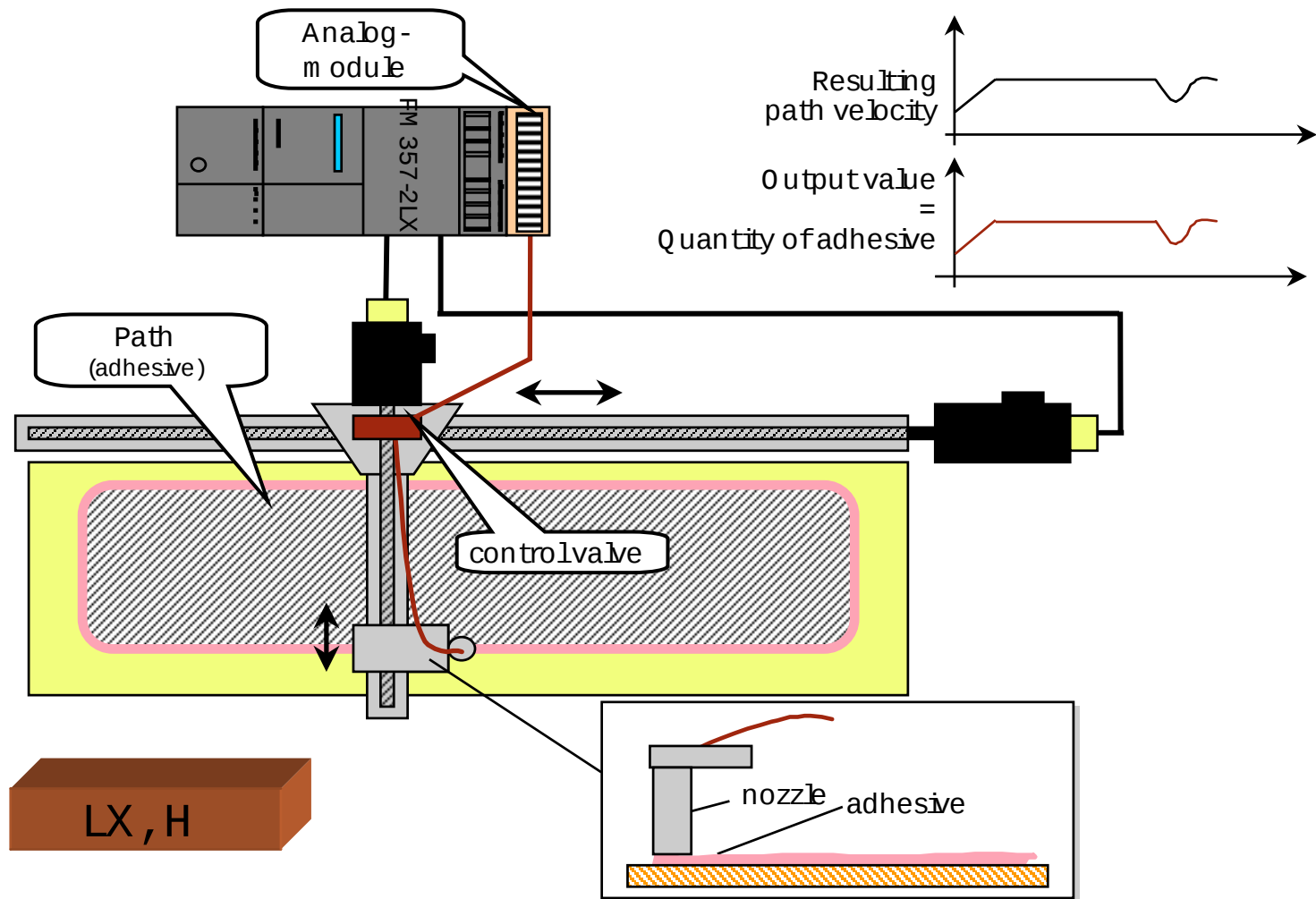
PU31xT-2DP Feature

PU31xT-2DP Application

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路径的速度，依赖于模拟量的输出





FM357-2 连续定长剪切的应用实例



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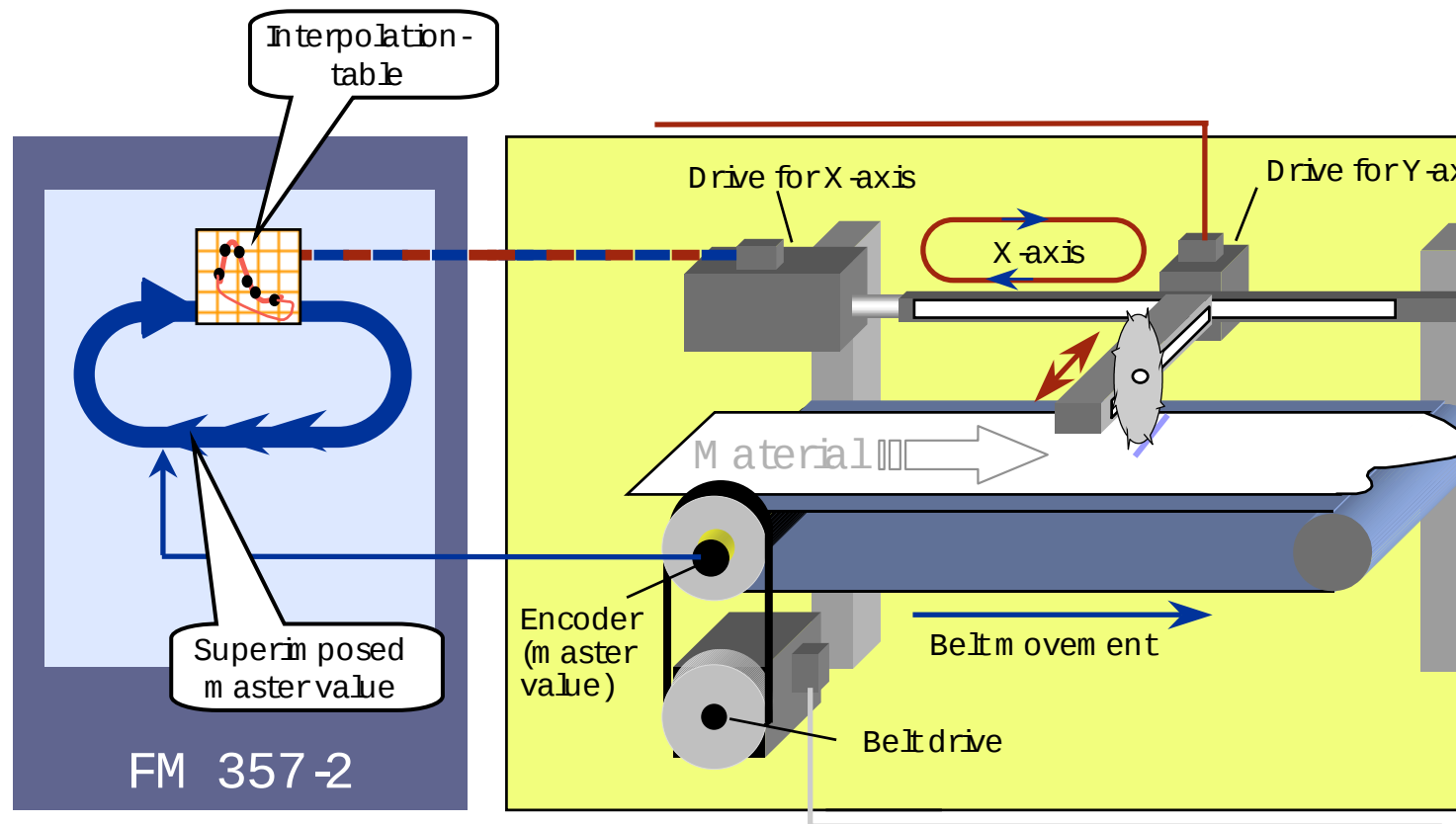
PU31xT-2DP Feature

PU31xT-2DP Application

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通过定义凸轮盘、轴之间的同步控制



L, LX, H



FM357-2 测量纸箱长度的应用实例



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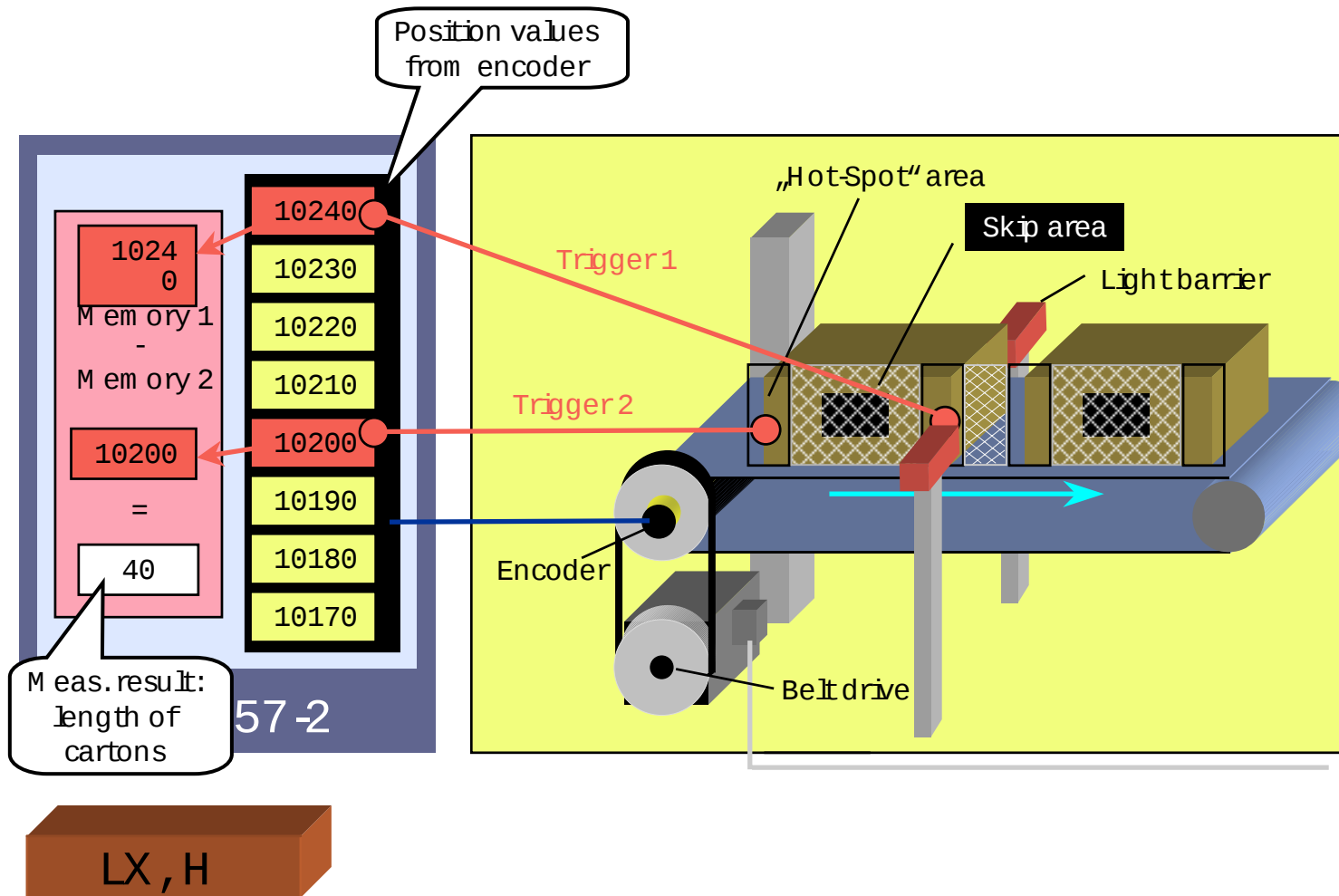
terface Module

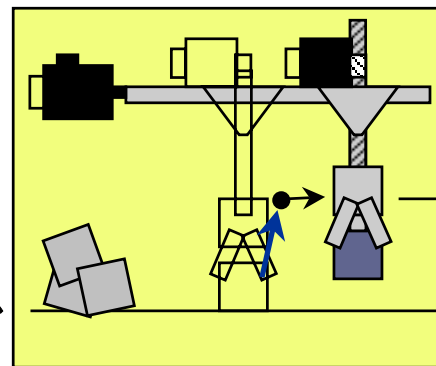
PU31xT-2DP Feature

PU31xT-2DP Application

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FM 357-2 模块程序被中断以后，可以重新从中断程序点，开始继续运行。



SIMATIC Technology CPU31xT-2DP 纵览

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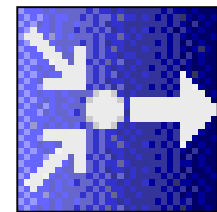
CPU 31xT-2 DP
+ fast I/O



Motion functions
PLCopen



Drive
configuration &
parameter



Technology
CPU (T-CPU)



CPU31xT-2DP 技术数据



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技术数据	CPU315T-2DP	CPU317T-2DP
轴	8	32
凸轮盘	16	32
凸轮开关	16	32
测量传感器	8	16
外部编码器	8	16
总的工艺对象	32	64
处理时间		
二进制处理	0.1 us	0.05 us
字运算	0.2 us	0.2 us
定点运算	2.0 us	0.2 us
浮点运算	3.0 us	1.0 us
工作存储区	128 kB	512 kB



SIMATIC Technology 组件包



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SIMATIC Technology CPU / software

- | | |
|----------------------|---------------------|
| ■ CPU 315T-2DP | 6ES7 315-6TG10-0AB0 |
| ■ CPU 317T-2DP | 6ES7 317-6TJ10-0AB0 |
| ■ MMC 4 MB(或者更大空间) | 6ES7 953-8LM11-0AA0 |
| ■ S7 Technology V3.0 | 6ES7 864-1CC30-0YX0 |
| ■ STEP 7 V5.3 + SP3 | 6ES7 810-4CC07-0Yxx |

软件选件包

- | | |
|----------------------|---------------------|
| ■ SCOUT CamTool V2.1 | 6AU1 810-0FA21-0XA0 |
|----------------------|---------------------|



PROFIBUS DP(DRIVE)

连接西门子驱动器组件



低精度和低动态特性的速度控制轴

- MICROMASTER 420/430/440 and COMBIMASTER 411 frequency converter
- MASTERDRIVES VC asynchronous drives

高精度和高动态特性的位置控制轴

- SIMODRIVE 611 U synchronous drive
- MASTERDRIVES MC synchronous drive
- SIMODRIVE POSMO CD/SI/CA distributed drives
- SINAMICS S drive range

更多可以连结到PROFIBUS DP(Driver)的组件

- PROFIBUS DP encoder SIMODRIVE sensor isochron
- ADI 4: Analog drives interface module
- IM 174: Interface of Profibus DP for analog drives, stepping drives, Hydraulic drives with AO +/-10V and "External encoder"
- ET 200M, ET 200S;



CPU31xT-2DP 定位系统组图



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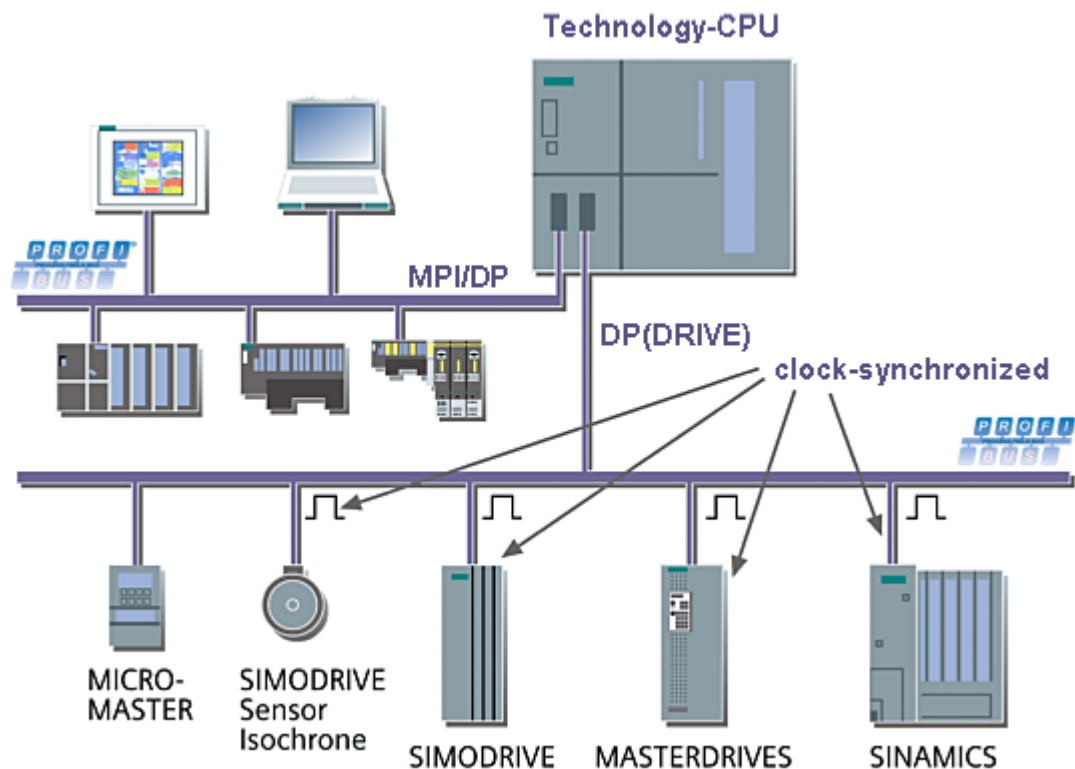
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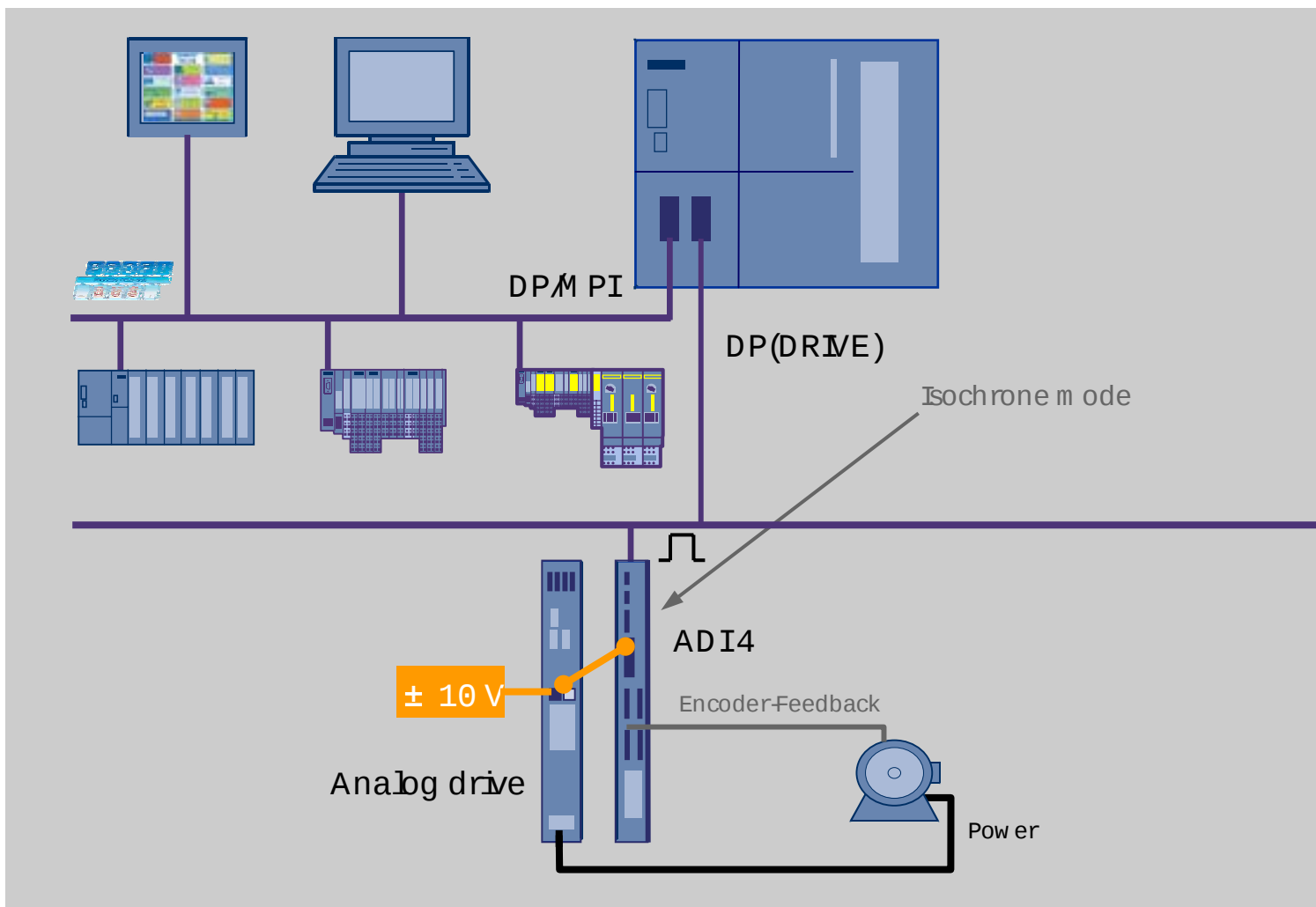
ernet

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ADI 4 接口模板

可以控制4轴的模拟量控制驱动器接口模板

订货号：6FC5 211-0BA01-0AA2





IM 174 接口模板

控制4轴模拟量控制驱动器，或者步进脉冲驱动器的接口模板

订货号：6ES7 174-0AA00-0AA0

模块特点：

- 通过Profibus DP，以等时模式，最大支持12M的通讯速度，连接驱动器；
- 有4个编码器接口，可以连接RS422接口的长线驱动型增量编码器或者SSI绝对值编码器；
- 4个+/-10 V 的驱动器的控制接口；
- 4个步进电机驱动器的控制接口，可以选择连结或者不连结编码器
- 10个24 VDC 的DI，8个24 VDC (0.5 A) 的DO；
- 2个继电器作为“驱动器准备”信号，4个继电器作为“4轴使能信号”
- 接口模板上有4个用于帮助诊断的指示灯；
- 外围尺寸：(WxHxD) 160mm x 125mm x 130mm；

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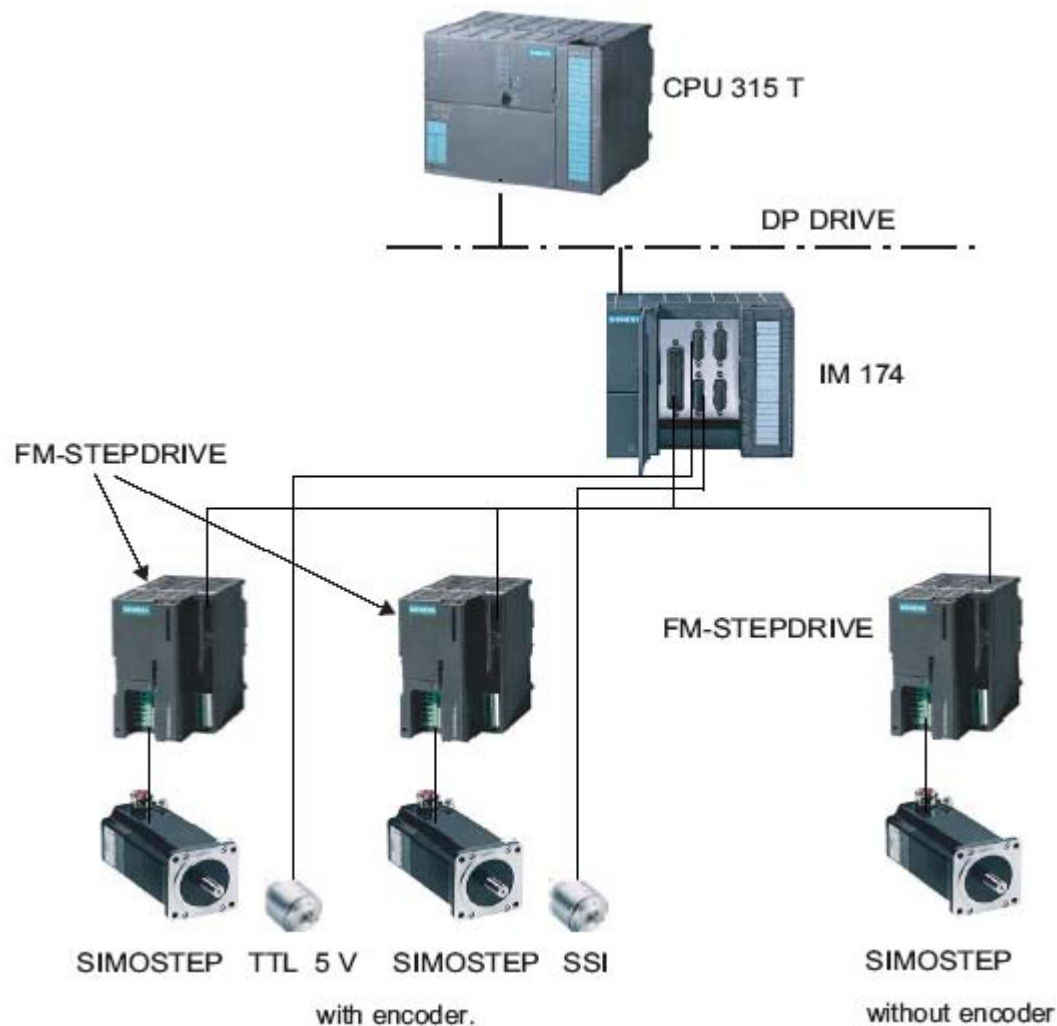
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CPU31xT-2DP DSC功能 (1)



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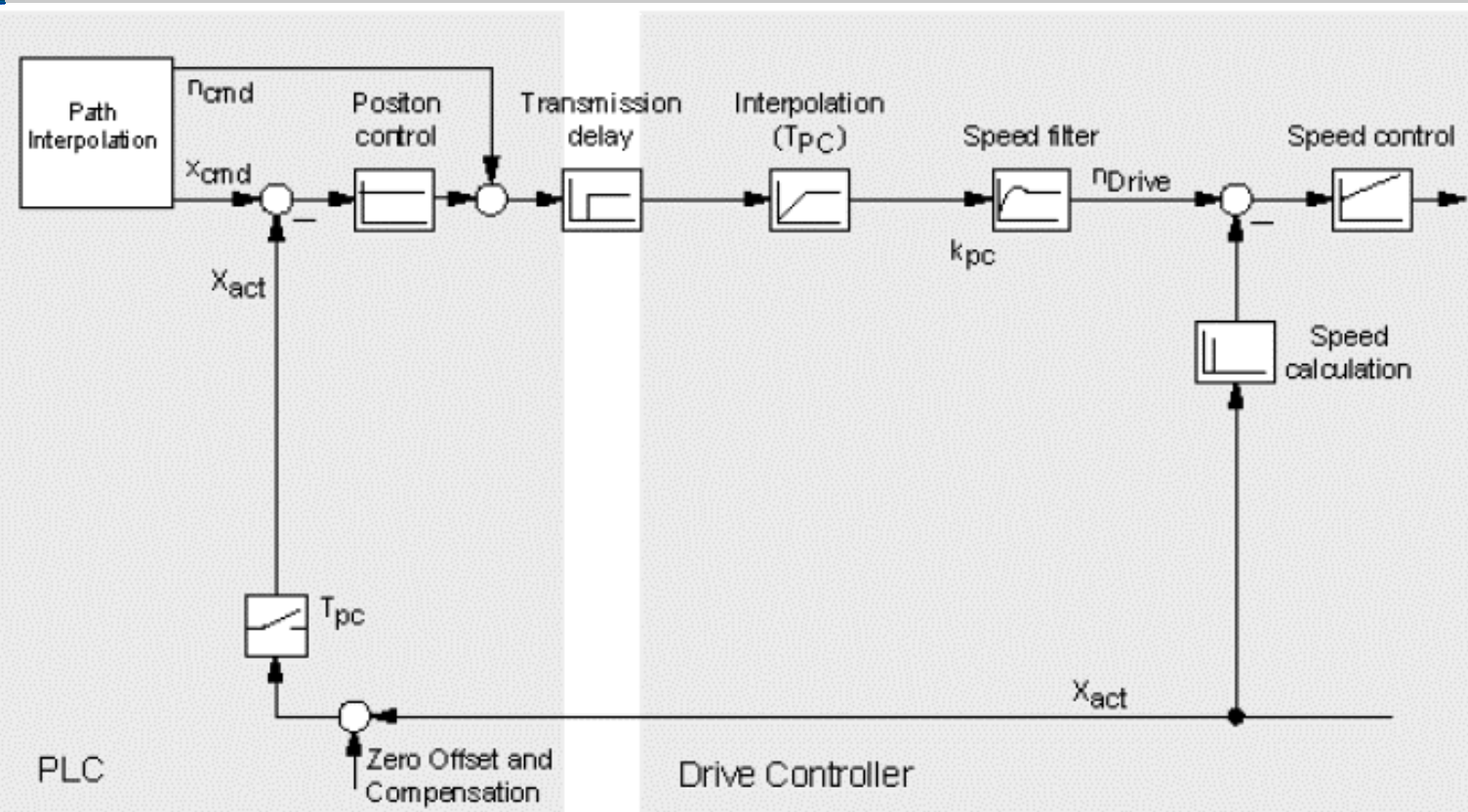
terface Module

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未启用DSC功能



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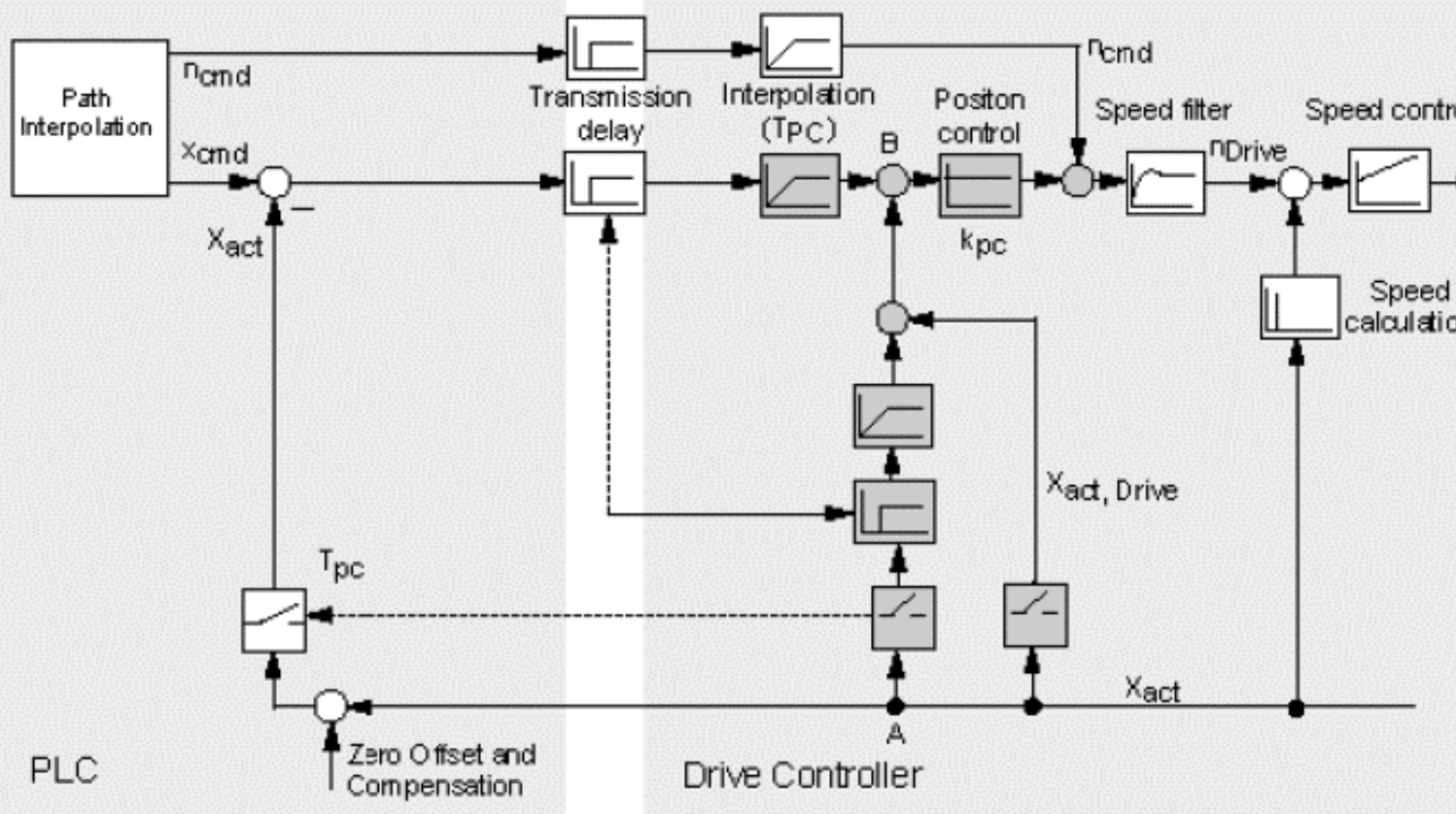
PU31xT-2DP Feature

PU31xT-2DP Application

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CPU31xT-2DP DSC功能 (2)



n_{cmd} : speed command
 x_{cmd} : position command
 x_{act} : actual position

T_{pc} : position controller sampling time
 k_{pc} : position controller gain

启用DSC功能



CPU31xT-2DP DSC功能 (3)



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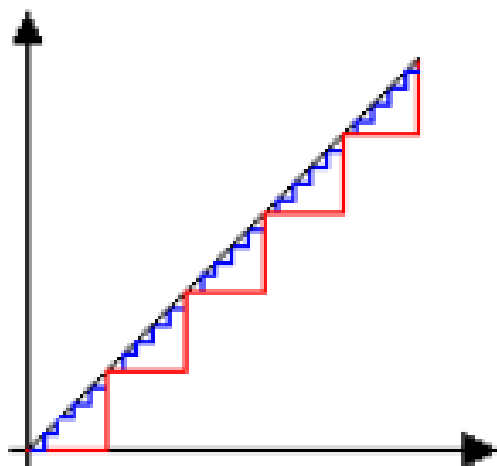
Interface Module

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■ Drive / actual value

■ Technology CPU / actual value

启用DSC功能后，运动控制效果说明



CPU31xT-2DP 基本功能介绍



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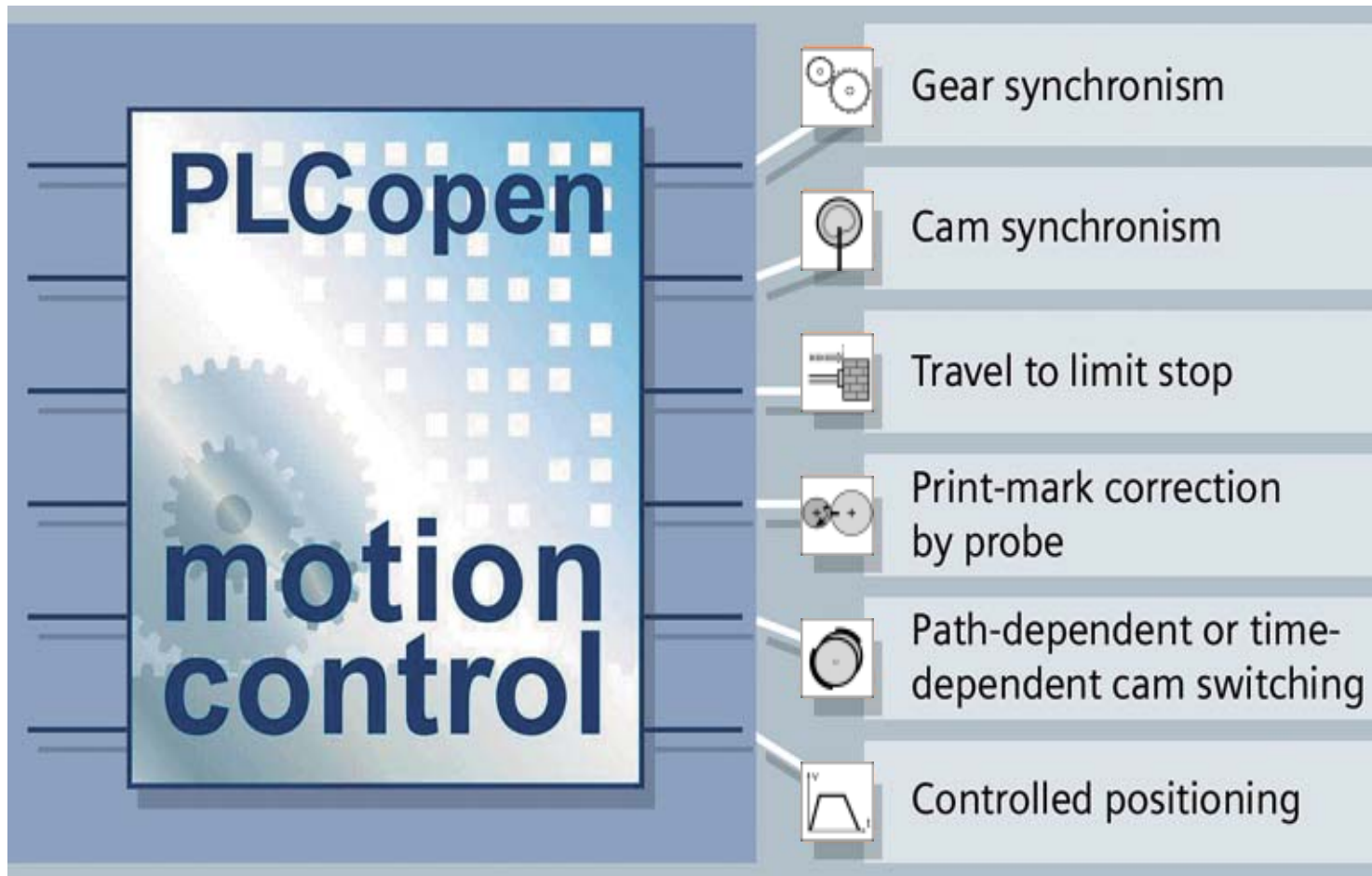
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适应PLCopen的运动控制命令



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Basic functions:

M C_Pow er	Enabling/disabling of an axis
M C_Reset	Fault acknowledgment
M C_Hom e	Hom ing/setting of axis
M C_HaIt	Standard stop
M C_Stop	Em ergency stop
M C_Cam Sw itch	Position-based cam
M C_Cam Sw itchTin e	Position/tin e-based cam
M C_ReadSysParam eter	Read M C param eters, various data types
M C_W riteParam eter	W rite M C param eters, various data types

Single-axis com m ands:

M C_M oveAbsolute	Absolute positioning
M C_M oveRelative	Relative positioning
M C_M oveAdditive	Relative positioning to current target position
M C_M oveSuperim posed	Superim posed positioning
M C_M oveToEndPos	Travel to a dead stop/clam p
M C_M oveVelocity	Speed input



适应PLCopen的运动控制命令



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Synchronism commands:

M C_GearIn	Gearing;engaging
M C_Cam In	Cam m ing
M C_Phasing	Phase shifter
M C_Engage	Engaging/disengaging
M C_GearOut	End synchronous operation
M C_Cam Out	End cam m ing

Cam processing :

M C_Cam Clear	Clear contents of a cam
M C_Cam SectorAdd	Add sector of a cam
M C_Cam Interpolate	Recalculate cam

Functions which are not axis-related :

M C_ExternalEncoder	External encoder
M C_MeasuringInput	Measuring input



在STEP 7软件中的硬件组态



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HW Config - [SIMATIC 300(1) (Konfiguration) -- 317T_Project2]

Station Bearbeiten Einfügen Zielsystem Ansicht Extras Fenster HFe

PROFIBUS[1]: DP-Mastersystem (1)

View of available drives

Profile: SIMATIC Technology-CPU

- CPU 317T
 - SIMATIC 300
 - PROFIBUS-DP (x1)
 - PROFIBUS-DP (x3)
 - Antriebe
 - MICROMASTER 4
 - MASTERDRIVES CBP2
 - SIMODRIVE
 - SIMODRIVE 611 uni
 - SIMODRIVE POSM0
 - SIMODRIVE POSM0
 - SIMODRIVE POSM0
 - SINAMICS
 - Weitere FELDERGÄTE

(Q) UR

Steckplatz	Baugruppe	Bestellnummer	Firmware	MP1-Adresse	E-Adresse	A-Adresse	E-A...	A...	K...
1	PS 307 5A	6ES7 307-1EA00-0AA0							
2	CPU 317T-2 DP	6ES7 317-6TJ10-0AB0	V1.0	2					
X1	MP1-DP			2	8191*				
3	Technologie	6ES7 317-6TJ10-0AB0	V2.1						
X2	DP				1022*				
X11	E/A				66	66			
4									
5									
6									
7									
8									

6ES7 317-6TJ10-0AB0 (V1.0)
DP-Slave, Drive ES-Schnittstelle



在Trace界面下进行诊断



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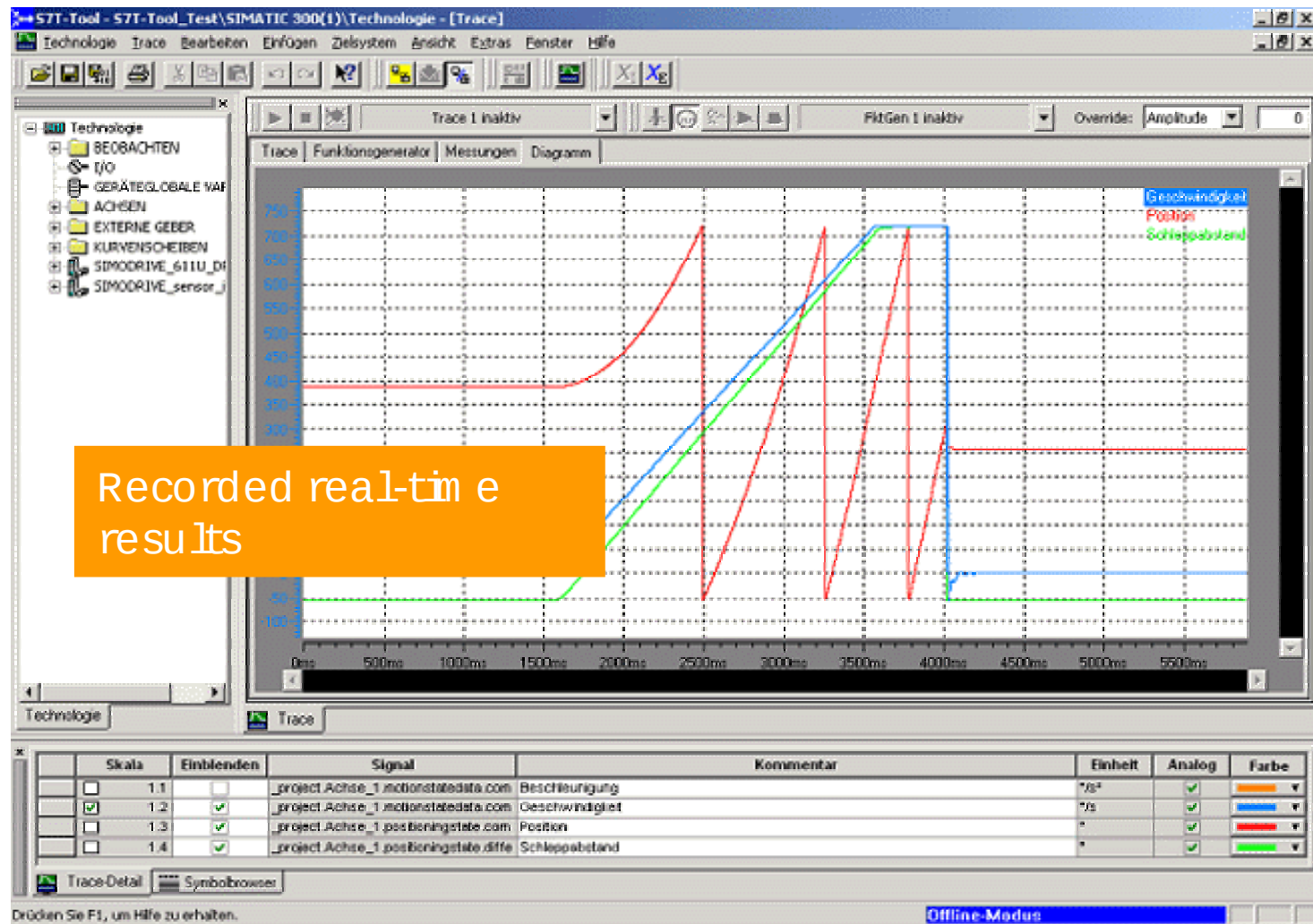
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工艺组件对象，生成相应数据块DB



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SIMATIC Manager - 317T_Project2

317T_Project2 -- d:\Siemens\Step7\proj\317T_P_1

317T_Project2

- SIMATIC 300(1)
 - CPU 317T-2 DP
 - S7-Programm(1)
 - Quellen
 - Bausteine
 - Technologie
 - SIMODRIVE_611U_1
 - SIMODRIVE_611U_2

Technologieobjekte

Technologieobjekte

Zugeordnete technologische Objekte

	DB	Symbol	Technologieobjekt	Kommentar
☐	DB1	Achse_1	Achse_1	Positionierachse
☐	DB2	Kurvensch...	Kurvenscheibe_1	Kurvenscheibe
☐	DB3	Achse_2	Achse_2	Gleichlaufachse
☐	DB4	traceDB	traceDB	S7-Daten für Trace des MC-Sub...
☐	DB5	MCDevice	MCDevice	Status des MC-Subsystems

↑ Zuordnen

↓ Löschen

Nicht zugeordnete technologische Objekte

	DB	Symbol	Technologieobjekt	Kommentar
--	----	--------	-------------------	-----------

Technologie bearbeiten ...

Aktualisieren

Schließen

Hilfe



在STEP 7软件编程界面下，FB功能块的调用



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Interface Module

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PU31xT-2DP Application

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KOP/ANL/FUP - [081 -- CPU317T_project\SIMATIC 300(1)\CPU 317T-2 DP]

Objekt Bearbeiten Einfügen Zielsystem Test Ansicht Extras Fenster Hilfe

Objekt: Schnittstelle

Inhalt von: 'Umgebung\Schnittstelle'

Name: TEMP

KOMMENTAR:

"Positionieren abs"

"MC_MoveAbsolute"

"Kette1".Status -> EN

6 -> Axis

"Kette2".Done -> Execute

1.000000e+002 -> Position

5.000000e+001 -> Velocity

3.000000e+001 -> Acceleration

3.000000e+001 -> Deceleration

1.000000e+000 -> Jerk

0 -> Direction

0 -> DoneFlag

"Positionieren abs".Done -> Done

CommandAborted -> ...

Error -> ...

ErrorID -> ...

ENO

Reference to DB for configured axis and positioning



T-CPU应用—精确传送定位



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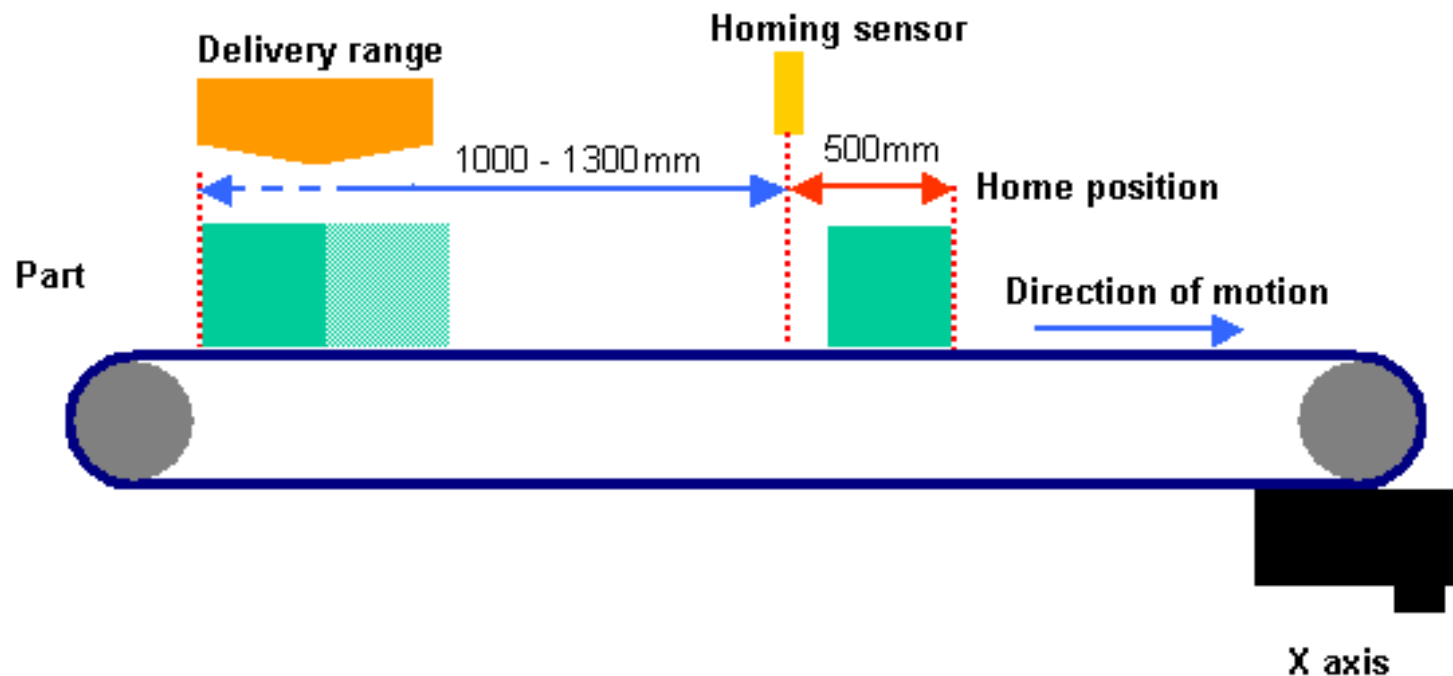
Interface Module

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在传送带上面放置货物的初始位置不固定，通过Homing sensor传感器，可以精确地将货物定位在预先指定的固定位置。



T-CPU应用—飞剪(2)



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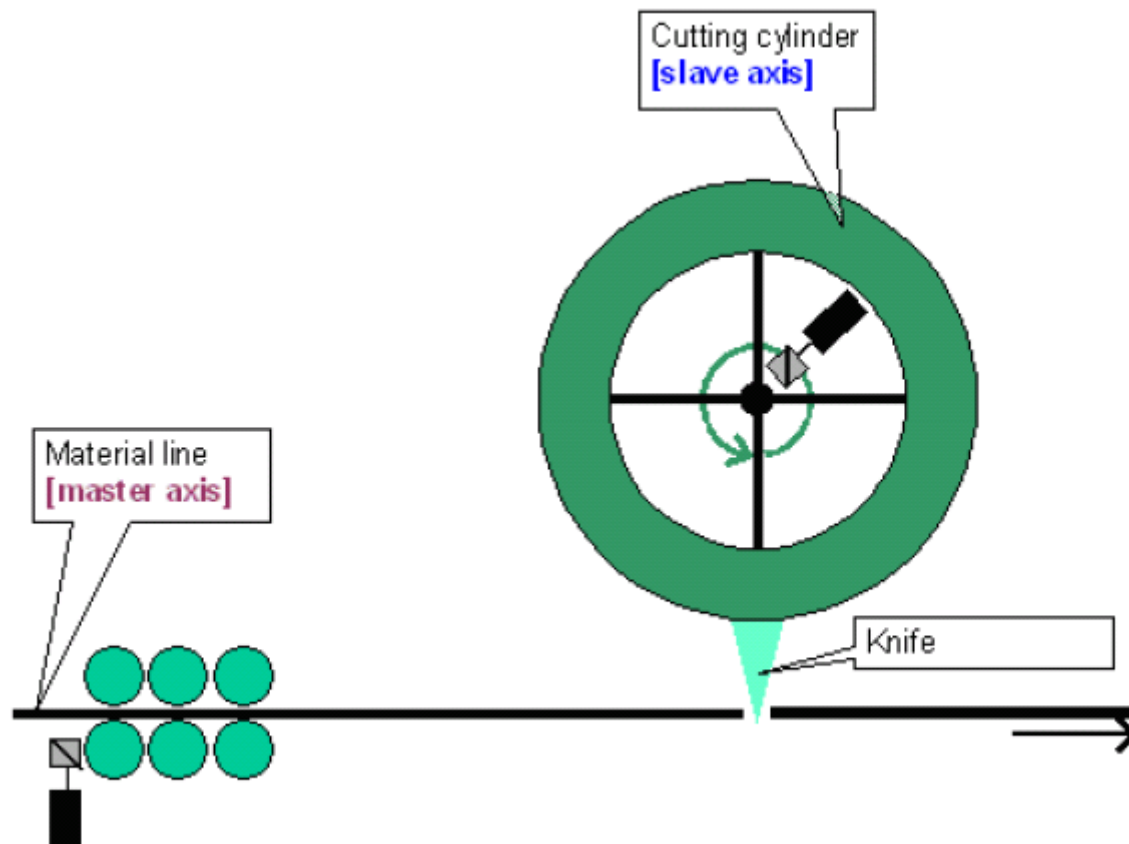
Interface Module

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T-CPU应用—夹钳送料



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rofibus DP (Drive)

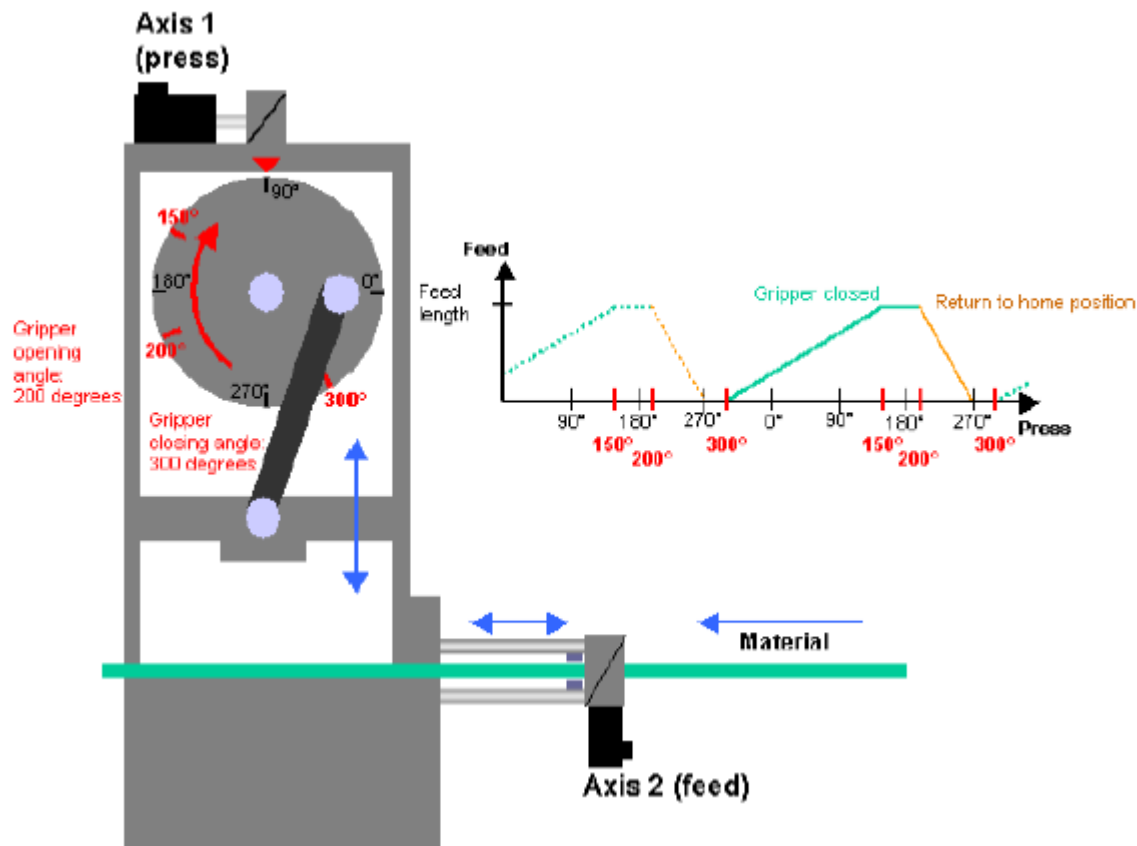
terface Module

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这是一个“夹钳送料”的典型应用实例。轴Axis1是一个旋转轴 (Master Axis)圆周连续运转，轴Axis2是一个直线轴来回往复运动。两个独立的轴通过一定位置关系的同步，实现“夹钳送料”的传送工艺；

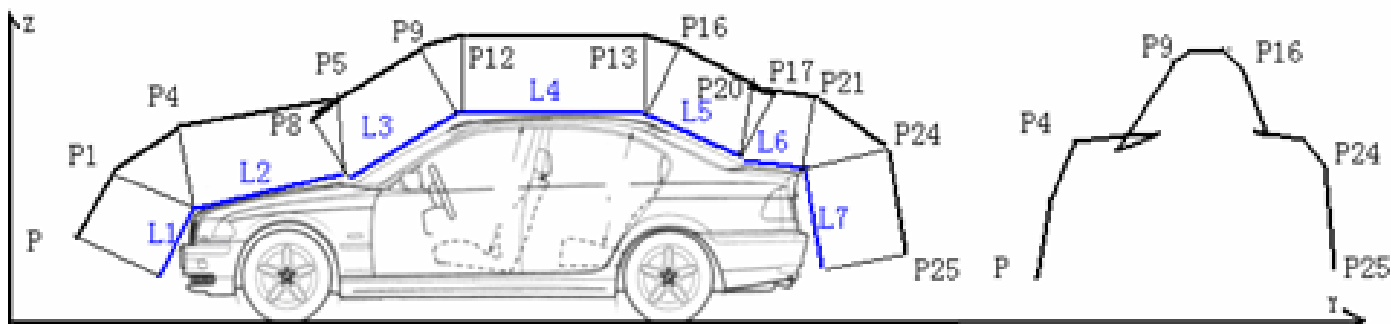


T-CPU应用—轿车仿型喷漆（2）



■CPU317T-2DP 在仿形轨迹控制中的应用

喷涂系统的顶喷机,用六个西门子伺服电机驱动横梁及喷杯,在五个自由度上的运动。要求横梁两端的驱动电机运动时完全同步,并与其他电机在仿形过程中同步运行完成仿形。应用CPU317T-2DP中的 Synchronism Technology functions 功能及 Cam disks 功能很好地解决同步过程。对于横梁两端的电机用 Gear_in 命令使两电机完全同步。在仿形过程中,巧妙地应用了 CPU317T-2DP 中的虚拟轴概念,设定了一个不存在的虚拟轴,此轴的运行轨迹为喷杯车形轨迹,速度为相对车体表面仿形速度及转角速度,并使Y轴,Z轴,A轴与此轴同步完成车体仿形,进而简单、有效地解决了这个复杂仿形问题。



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T-CPU应用—制袋包装机



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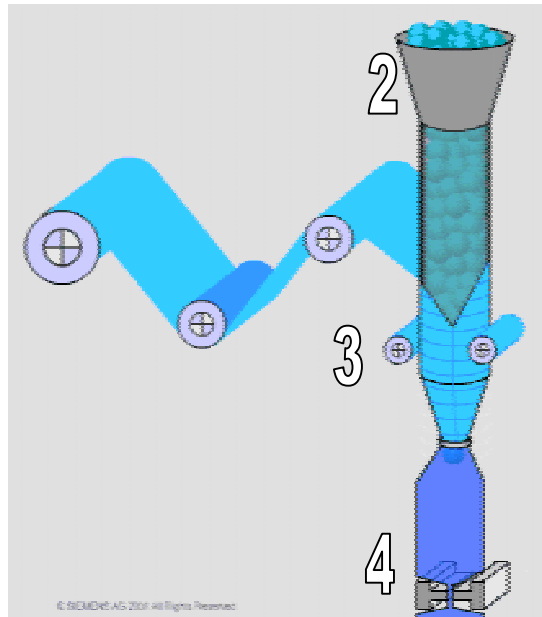
terface Module

PU31xT-2DP Feature

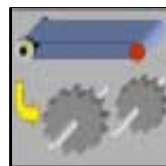
PU31xT-2DP Application

ernet

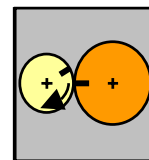
SIEMENS



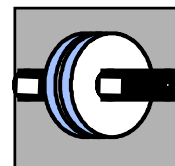
1. 薄膜传送
2. 定量进给，如螺旋进给系统
3. 纵向封口单元
4. 横向封口单元



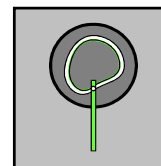
主值匹配



印刷标记/
设备标记的校正



电子离合器



电子凸
轮

同步功能下的运动控制

- 使用印刷标记，薄膜上的标记可以被光电管检测出来
 - 在 S7 Technology 中方便地设定一个虚主轴，所有的运动轴都用它来定位
- ### 加工动作序列 / 轴耦合
- 通过 SIMATIC T-CPU 系统对轴加以控制
 - 3号轴和4号轴通过凸轮进行同步操作
 - 启动虚主轴时，1号轴也随之启动，推动薄膜进给
 - 当2号轴在灌装袋子时，后面的薄膜将被送到存储容器中等待处理



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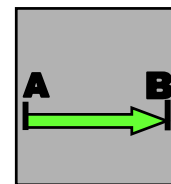
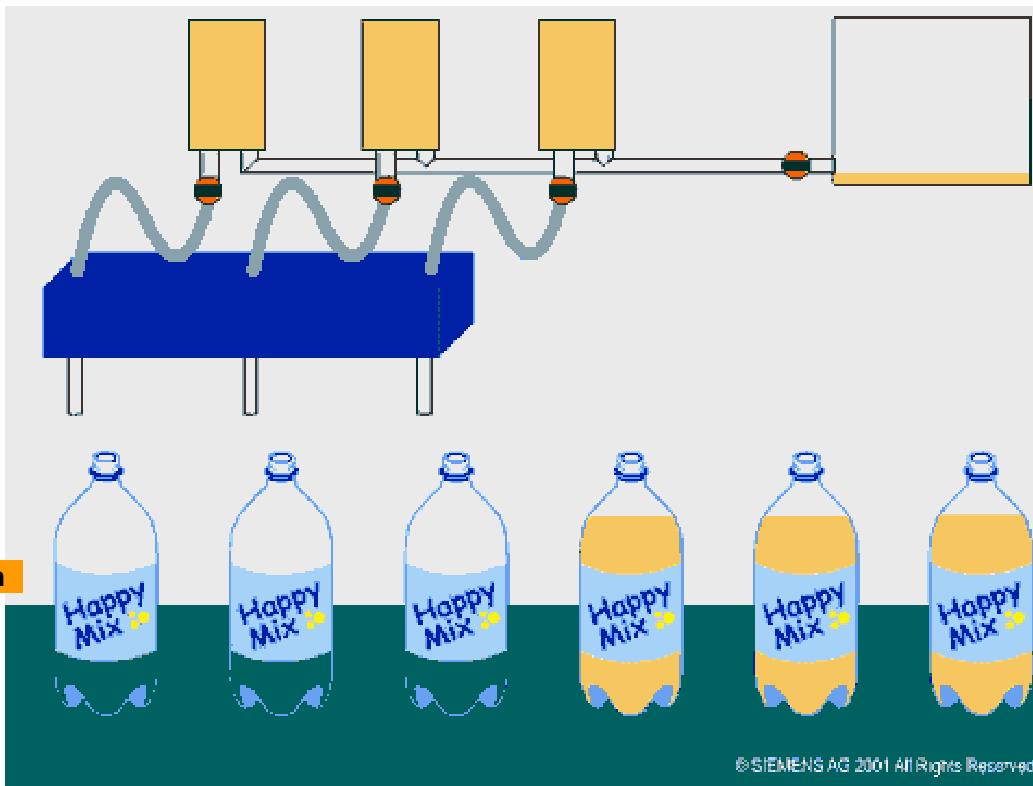
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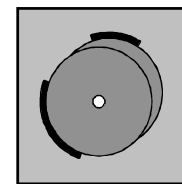
T-CPU应用—容器灌装



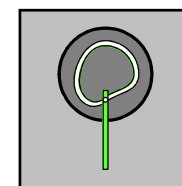
- 为了在灌装设备上对容器进行合适的灌装，有必要为灌装过程精确地指定灌装度
- 定量给料活塞凸轮的控制由瓶子的几何容积决定
- 与机械方案相比具有无以比拟的优势
- 在同一位置改变或灌装不同的产品，需要在凸轮上进行转换



定位



凸轮控制器



电子凸轮



T-CPU应用—定位 / 起重与升降设备



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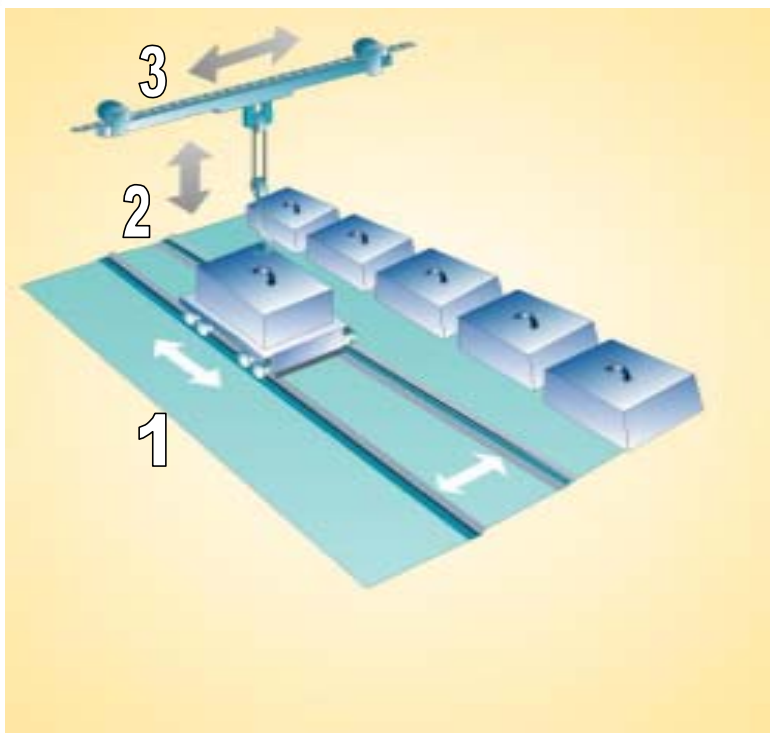
Interface Module

PU31xT-2DP Feature

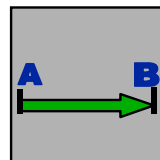
PU31xT-2DP Application

ernet

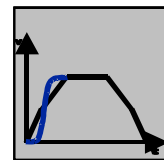
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1. 原料通过运动设备进行传输
2. 起重与升降齿轮
3. 电车移动绞盘



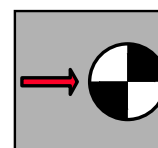
定位



冲击限幅
Optional DRIVEPAC



电子齿轮



参考点返回

运动控制

- 在这一应用中的驱动系统用于定位
- 位置设置通过 PROFIBUS分配比例给变频器，实现位置同步

加工动作序列 / 轴耦合

- 1号轴将运货小车拉到龙门起重机的传送位置上
- 当货物被吊起时，2号轴和3号轴将同时开始定位



T-CPU应用—码垛机 (Palletizer)



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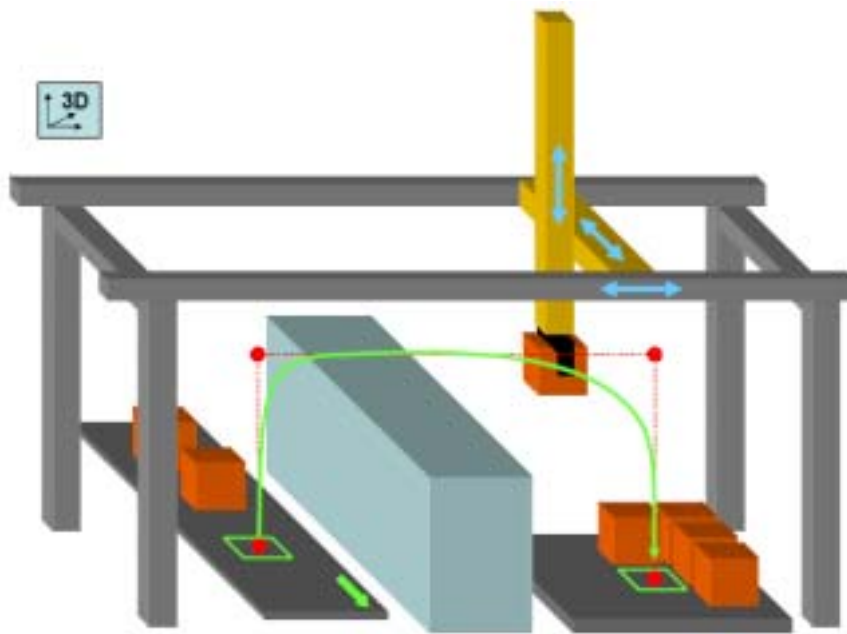
Interface Module

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T-CPU应用—环锭纺纱机



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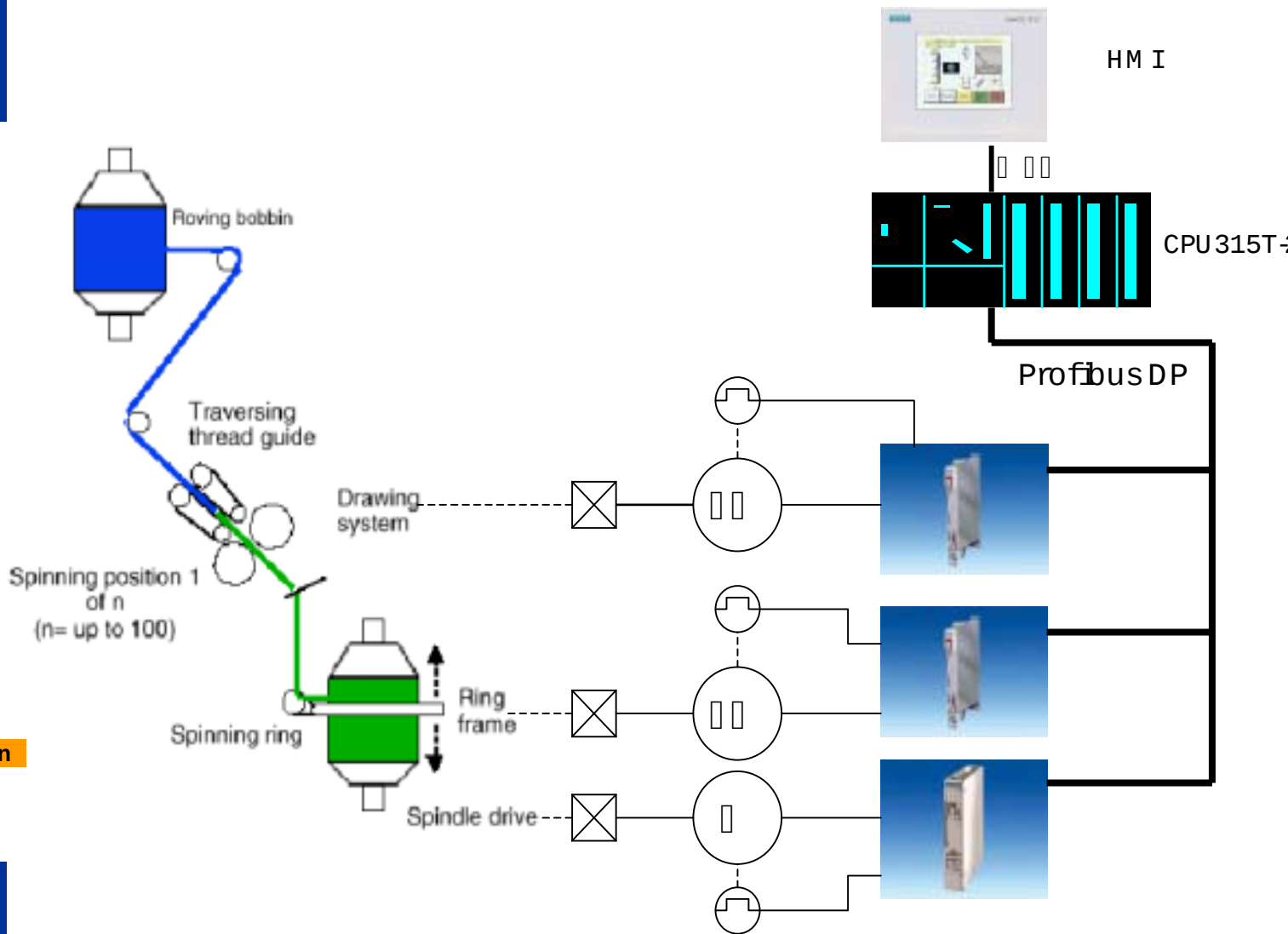
Interface Module

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- <http://support.automation.siemens.com/CN/view/en/1799440>