

## Automatic loading/unloading sequence

Productivity | Process Optimisation



### Series

H	F	C	MCH	MCH-C	MC
MCI	MCP-H				

### Control

SIEMENS Solutionline	SIEMENS Powerline
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Manual loading and unloading is time-consuming, expensive and can be a source of errors. With the automatic loading/unloading sequence, you save time and gain process reliability.

## Characteristics

- \_ During the automatic de-setting sequence after the pallet change, depending on the expansion stages present on the machine, the following sequences are executed automatically: Automatic workpiece unclamping on the workpiece setting station [with hydraulic workpiece clamping] and. Automatic unlocking of the safety doors on the workpiece setting station [with automatic doors]. If the required expansion stages are not contained in the machine, these operations must be carried out by the operator.
- \_ During the automatic setting sequence the setting sequence is started by pressing the setting key [stand-alone machine: "Preset start"]. After completion of the loading sequence, the pallet on the loading station is ready for automatic pallet change. Depending on the machine's expansion stages, the sequence comprises the functions: Automatic closing of the safety doors on the workpiece setting station [with automatic doors], Automatic locking of the safety doors on the workpiece setting station [with closed safety doors], Automatic clamping of the workpieces on the workpiece setting station [with hydraulic workpiece clamping] and Automatic positioning of the setting station in the change position [automatically rotating setting station]. If the required expansion stages are not contained in the machine, these operations must be carried out by the operator.

## Benefits

- \_ Shorter setting and de-setting times: automated sequence significantly reduces setting and de-setting times, increases savings potential when operating several machines
- \_ More safety: automated sequences ensure reliable production processes

## Requirements

- \_ Hydraulic workpiece clamping
- \_ Automatic setting station doors