

```
MOV K3300 D104
MPP
AND <=D104 K3300
MOV K330 D104
LDP SM1036
MOV K1000 D104
END
```

3 结语

两辊挤出压延联动生产线控制系统采用CC-

Link现场总线网络后,通过现场调试,两辊挤出压延联动生产线速度在 $3.5 \sim 35 \text{ m} \cdot \text{min}^{-1}$ 范围内可稳定、连续调节,能够完成各种工艺条件下的监控要求。CC-Link现场总线技术显著减少了挤出压延联动生产线的控制电缆。与传统控制方法相比,CC-Link现场总线网络具有操作简单、性能出色、通信速率快、易于维护等优点,有利于分散系统实现集中监控,提高了生产线自动化水平,降低了能耗,具有较好的控制效果和经济效益。

Control System of Two-roll Extrusion and Calender Production Line Based on CC-Link Field Bus

Liu Xicui, Wang Youjing, Men Xide

(Tianjin Saixian Technology Co., Ltd., Tianjin 300384, China)

Abstract: CC-Link field bus technology was applied in two-roll extrusion and calender production line. The CC-Link field bus network consisted of one master station, 23 remote I/O stations, 11 remote device stations and an intelligent device station. The network showed high-speed and high-deterministic input response, and had high network stability. With proper configuration of hardware and software, the speed of the production line was steady and continuously adjustable in the range of $3.5 \sim 35 \text{ m} \cdot \text{min}^{-1}$, the technical data met the requirements, and the system was reliable and easy to operate, offering good control and economic benefits.

Keywords: two-roll extrusion and calender production line; CC-Link field bus; control system

信息·资讯

阿波罗计划在东南亚建轮胎厂

印度阿波罗轮胎公司计划在东南亚地区新建轮胎厂,而拟建的东欧工厂可能要推迟2年。

亚洲地区是一个庞大且不断增长的市场,良好的发展前景是公司计划在亚洲布局的一个重要激励因素。要增强竞争力,在该地区拥有制造业

务至关重要。

虽然目前从印度出口的30%阿波罗轮胎发往东南亚,然而,其它世界轮胎巨头在东南亚地区已有生产基地。阿波罗的目标是在2013年3月31日前在东南亚开设销售和营销中心。 朱永康