





### The control system of palletizing system

The system is controlled by a total of five Beckhoff Industrial PCs, 4 of which are equipped with a 12 inch Control Panel. The control system is based on the TwinCAT software PLC. Each of the two robots is controlled by a control cabinet PC C6150. The palletizers are controlled by two C6240 series IPCs. The two-channel FC3102 Profibus interface card provides master and slave functionality. The robots and palletizers are served via the master channel; the slave channel is used for coupling with a central C3620 series built-in PC, which is equipped with 4 Profibus master channels.

The C3620 Industrial PC controls the movement of the cartons to the palletizer and to the robot, i.e. it serves 10 servo drives and 190 frequency

controllers as well as several bar code and cargo scanners. Communication between the computers is established via real-time Ethernet through the TwinCAT ADS router. The C3620 also communicates with the ERP system. The palletizing system consists of a total of approximately 300 Profibus stations, 150 servo drives and 1200 I/Os, yet the C3620 processor utilization is only 10 to 15%.

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