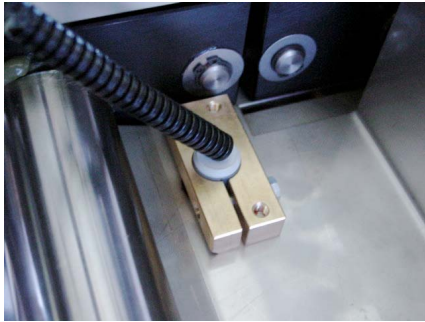


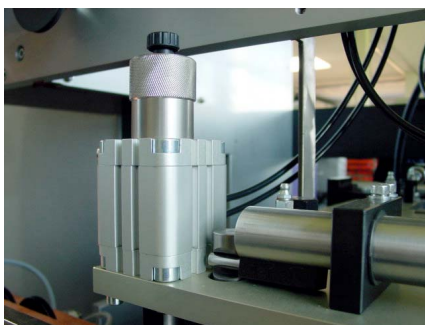
## 5.4.5. Double Sheet Function



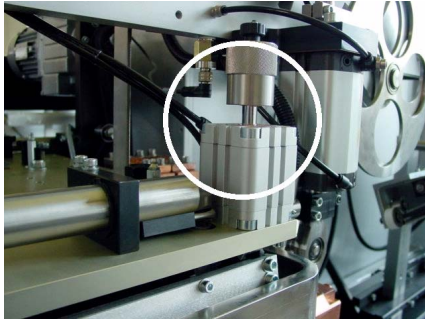
To detect double sheets, two sensors (transmitter/receiver) are mounted behind the first roller pair. Do not change their position!  
(Upper part of the sensor in the picture)



The lower part of the sensor is protected in an aluminium tube. Do not change its position!



Depending on the model, the bending roller or bending wedge is raised by one or two pneumatic cylinders. As a result, the double sheet will not be roll formed and will be transported directly to the collection container.



Double sheet:  
Active position – double sheet will be diverted into the collector.



The double sheets detected by the sensor will be diverted into this collector.



**NOTE:**  
If the quantity of 10 sheets is reached in the channel, a message will be displayed on the panel, "Double sheet collector full". The message will disappear if you remove and empty the channel and then remount it. The counter will not be reset by the switching ON/OFF of the installation.



**B84**

If the double sheet channel is not in its position, Sensor B84 initiates a fault message. This causes the production to be shut down. The production cannot be started without the double sheet collector.

## Setting the double sheet sensor

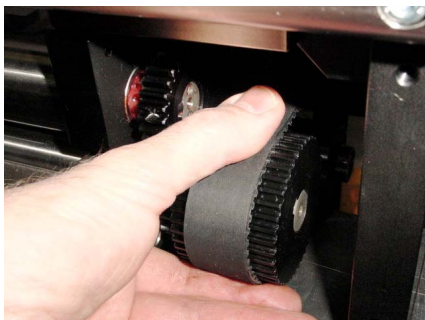


B30

The evaluation unit for the double sheet sensor is located in either the control box (illustration) or in the immediate vicinity of the rollformer, on the feeder side.



To set the sheet thickness, take two sheets and lay it on the support rails in front of the first roller pair. You can also open the rollformer and lay a sheet into the rear area by hand. Then close the rollformer again.

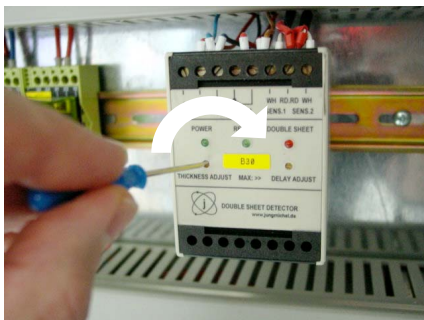


Now turn the single sheet back and forward in the first roller pair by hand with the help of the belt.

## a) LED "Double Sheet" flashes up



The two green LEDs „Power“ and „Double Sheet“ should now flash up on the evaluation unit. To make the fine tuning, you do the following:

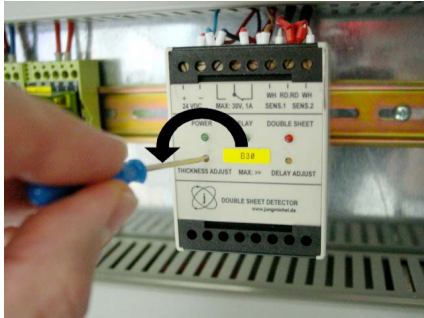


Turn the left-hand screw „Thickness Adjust“ clockwise until the red LED goes out and the green LED „Relay“ flashes up. Then make 1-2 revolutions in the counterclockwise direction, until the LED „Double Sheet“ flashes up again.

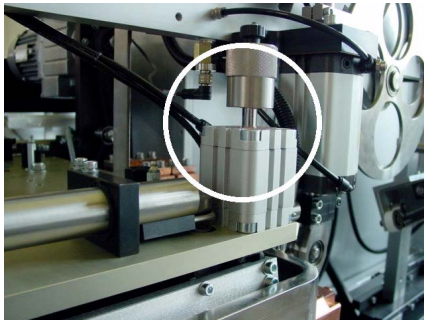
## b) LED "Double Sheet" does not flash up



If the red LED „Double Sheet“ does not flash up, but green LED „Relay“ does, you must carry out a correction.



Turn the left-hand screw „Thickness Adjust“ counterclockwise until the red LED „Double Sheet“ flashes up again and then make 1-2 more revolutions in counterclockwise direction.



The cylinder should now also be activated. It will be reset again when the sheets are removed.



Do not turn the right-hand screw „Delay adjust“; this is used for the delay of the cylinder stroke.

**NOTE:**  
You will find further details on the CD in Book 5.



**NOTE:**  
In case you change to a very different blank thickness, you check the fine tuning again.