UMAC® – WALLMASTER

Ultrasonic Measurement & Control Systems for Wall Thickness & Eccentricity
UMAC® WALLMASTER SYSTEMS: INCREASE THE EFFICIENCY

UMAC WALLMASTER systems from ZUMBACH allow in-line measurements, data acquisition and control during the extrusion of a wide range of products, like tubing, pipe, hoses and cables. Cutting edge digital technology (DSP) opens up measuring solutions for each process and product:

- Ultra thin walls
- Smallest and largest diameters
- Multi-layer products
- Cable isolations and jackets
- Products of irregular geometry

Special products requiring an off-line QC measurement can now be measured in-line and relevant parameters monitored continuously. The diameter can also be measured in a combination with the ultrasonic measurement with certain scanners. In addition, UMAC WALLMASTER systems provide for real-time QC data, process monitoring, trending, SPC data, statistical charts etc.

Economic Advantages

- Reduced set-up time
- Raw material savings
- Scrap reduction
- Continuous process monitoring and control
- Fully automated QC and data collection
- Reporting
- ROI within few months

Technical Advantages

- Easy operating
- Automatic calibration
- Digital Signal Processing (DSP)
- Multi-layer measurement (up to 5 layers simultaneously)
- Measurement of thin walls down to 0.05 mm (.002 in.)
- Thick walls up to 99.95 mm (4 in.)
- Product diameters from 0.2 to 350 mm (.008 to 13.8 in.)
- Flexible configuration, even for products of irregular geometry
- Complete process transparency and control

Ultrasonic Measurement Principle

It is based on the time difference (t₂) of the sound echoes from the surface and the inner side of the product. A piezoelectric crystal is excited by a short electrical pulse. The crystal converts electrical energy into mechanical energy, i.e. sound waves. When the sound waves encounter a difference in the propagation medium (for instance when passing from water to a synthetic material), a part of them is reflected back to the crystal (echo).

Wall thickness = Sound velocity of material • t₂ • 0.5

ZUMBACH SmartWall®

Zumbach ultrasonic wall thickness measurement utilizes the intelligent SmartWall® algorithm to dynamically analyse, configure and optimise all signal parameters during the set-up of each production run taking the guess work away from the operator.

Advantages

- Fully automatic signal optimization setting of all key parameters
- True echo wave signal processing minimizes the effect of echo shape on accuracy
- Dynamic signal analysis continuously monitors the quality of the signals being processed
TYPICAL APPLICATIONS

Measurement of Insulations or Jackets on Cables
For the extrusion of cores or jackets the WALLMASTER system offers many possibilities thanks to its flexibility and ease of configuration. All parameters, thickness, eccentricity, diameter and ovality, can be monitored and controlled.

- For core insulation
- For jackets, also when loose or non-round
- For co-extrusions
- Automatic calibration with DIACAL system
- Hot/cold compensation

Wall Thickness and Diameter Control on Tubing and Hoses
For this range of products all combinations are possible for measurement and control of wall thickness, outside and inside diameter.

- UMAC scanners for incorporation within or outside of vacuum tanks or cooling tanks
- ODAC laser scanners for accurate diameter/ovality measurement
- Addition of servo valves, fault detectors etc.

Wall Thickness Measurement and Control During the Extrusion of Pipe up to Ø 620 mm (24.41 in.)
Scanners are available for measurement at the hot end or the cold end of the line. Optionally, also with integrated diameter measurement. At the hot end, the highest savings are possible:

- Directly after the forming sleeve
- At the exit of the vacuum tank or at the cold end of the line
High-Tech Measured Value Processors for Ultrasonic Wall Thickness Measurement

Industrial processor with DSP (Digital Signal Processor) technology for connection to a higher level system (PC, PLC or USYS, resp. WALLMASTER systems). For display and process control, the UMAC CI provides serial RS or a Profibus DP interfaces.

UMAC CI
- For single and multi-layer cables and tubes
  - Multi-layer measurement (up to 5 layers)
  - Wall thickness down to 0.05 mm (.002 in.)

UMAC CI B
- For single layer tubes
  - Automatic single layer measurement
  - Wall thickness down to 0.5 mm (.02 in.)

Multi Sensor Data Acquisition and Process Control Systems

The USYS IPC hardware provides a modular alternative to the other processor and display units of the USYS family. It offers the flexibility to mount the processor in a convenient location while mounting the flat panel touch screen at an optimum location for the operator.

USYS IPC 1e WALLMASTER
- Inputs: Up to 3 ODAC or MSD, detector, Start/Stop, Pause
- Up to 4 extension ports (digital & analogue inputs & outputs, relays, ODAC, MSD, etc.)
- 4 HU* box design

USYS IPC 2e WALLMASTER
- Inputs: Up to 6 ODAC or MSD, detector, Start/Stop, Pause
- Up to 7 extension ports (digital & analogue inputs & outputs, relays, ODAC, MSD, etc.)
- 4 RS-422 ports as standard, extendable to 8
- 19" rack 4 HU*

Display

Rack mountable touch screen for convenient installation into existing 19" rack (8 HU*) or extruder panel. As an alternative, a desktop touch screen or screen with keyboard and mouse are available.

DATA ACQUISITION, PROCESSING AND DISPLAY SYSTEMS

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* HU = Height Unit; 1 HU = 44.45 mm (1.75 in.)
➤ For detailed specifications of the individual components, please ask for specific data sheets.

Accessories / Peripherals

19" cases/cabinets, keyboard, mouse, printers, remote displays, vacuum and pressure control valves.
UMAC A5 / A10 / A20
Open and compact scanner.
These A scanners are available in two versions:
– K version: for standard water trough installation (height adjustment from the top)
– V version: for vacuum tank installation (height adjustment from the bottom)

UMAC RZ35 / RZ65
Ring-shaped measuring chamber with two pairs of sliding guides, opening up automatically; each diameter requires 1 set of guides. Simple adjustments to suit the new product diameter in just a few seconds. All transducers are symmetrically positioned with a central adjustment.

UMAC Z50 / Z100 / Z180
Two quick hand adjustments to suit the new product diameter take just a few seconds. All transducers are symmetrically positioned with a central adjustment. Large measuring range with the same scanner.

UMAC R
Fixed transducer holder for 4, 6 or 8 measuring points. Ring shaped transducer mounting fixture custom configured for installation into existing vacuum tank. This UMAC® R scanner is installed inside the vacuum tank on to the bulk head separating the first and second vacuum chamber.

UMAC ULTRASONIC SCANNERS

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<th>Meas. points</th>
<th>Diameter range mm</th>
<th>Diameter range inch</th>
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<td>0.2 ... 5</td>
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<td>0 ... 2.56</td>
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<td>UMAC Z180-6K</td>
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<th>Diameter range inch</th>
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<td>50 ... 620</td>
<td>1.97 ... 24.41</td>
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Scanners for other diameter ranges upon request.

Accessories for UMAC Scanners

**Holders (H versions)**
Holding platform for the scanner for direct mounting into existing cooling trough or water basin of the F versions.

**Guiding blocks**
These blocks guarantee a proper guiding of the product through the scanner.
(Available for A and RZ scanners)

**Water basins (F versions)**
Additional water basin for the accommodation of the scanner (with or without H version).

**Overflow basins**
For mounting on the water basin (F version).
**IMPROVE AND SIMPLIFY PROCESSES**

**DIACAL 8000**
For Compensation and Automatic Calibration of the Wall Thickness. DIACAL 8000 is a smart method for the simplified calibration during the extrusion of cable jackets.

**Benefits**
- Precise wall thickness measurement of cable jackets
- Automatic calibration of the ultrasonic measurement through intelligent processing of the diameter measurement
- Economic solution because it employs the existing and essential diameter measuring instrument
- Optimises material consumption
- Generally improves the process

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**SIGMA-EXPERT and CpK-Pilot**
Sigma Expert – this sophisticated, self-tuning control algorithm automatically adapts to process and product conditions to ensure tightest control possible. CpK-Pilot statistically analyses the process capability and adjust the set-point for optimum material savings.

**USYS Data Log**
For quick and easy data logging to a PC or network file server to a text delimited (CSV) file. USYS Data Log is a Windows™ based software for convenient configuration of the data to be provided by the USYS processor.

**USYS Web Server**
For integration into local and wide area networks (LAN, WAN) the optional USYS Web Server software module allows for work stations configured with a standard Internet browser to access and view the USYS IPC WALLMASTER screens remotely. Providing insight information about the process and product being manufactured.

**USYS Report Manager / Report Viewer**
Historical storage of all printed reports such as trend charts, package summaries and SPC charts locally or on the network (XML format). Reports can be retrieved by the USYS for display.

Report Viewer installed on the PC will provide access to the reports from previous production runs for viewing and printing (ISO 9000 traceability).

**OPC UA**
Communication protocol for Windows. The OPC UA technology is a standard in the area of process control such as SCADA or HMI. It defines a common interface for accessing data of peripherals. The application "Zumbach OPC Server" provides the measured values and enables editing product recipes. The software operates with Windows 2000, XP, Vista or 7.

* For USYS 200, USYS IPCe. (OPC version for USYS 20).

**Other products and measurement technologies**
Further sensors for the measurement of other parameters such as diameter with laser technology, capacitance as well as lump and neckdown detectors (fault signal), surface inspection systems, conductor preheaters and temperature measurement, spark testers, scanners based on x-ray technology, lengths and speed measuring systems etc. complete the product range from ZUMBACH.

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* Technical specifications are subject to change without notice