

Customer: Kautex

Location: Lavonia, GA 30553

Time & Duration: 30 Days

Reference: Kautex 15008/ 1.1.6



Job Description

Customer wants a 6RA70 (Siemens DC Drive) checked out to be sure it is working properly after they had replaced the motor.

INP Tasks

Drive 6RA7085 - 6DS22-0-Z Options: G94, D64, K00, K01, K11

Motor Data: Antriebstechnik GmbH FAURNDAU

- During a normal routine preventative maintenance task conducted by Kautex, they replaced the brushes on the DC motor.
- When Kautex was running the machine below normal operational RPM, when they increased the speed the drive would trip. The HMI showed a thyristor fault but after investigation, the drive the fault is actually I squared T, i.e. over temperature. This will need to be corrected in the HMI.
- INP downloaded the drive parameters and began to review the settings.
- Checked the HMI to obtain history on what had been happening since the motor was replaced.
- The field current was set for 3.1 amps but according to the nameplate it should be 3.2 amps at base speed, this was changed while on site to 3.2 Amps and checked with DC clamp on ammeter.
- It was determined that with Virgin material in the extruder (used only to purge extruder system), there is a significantly more load than running the regrind material which is the normal product they run.

Conclusion

The system is still overloaded due to mechanical or process problem(s). It was decided by Kautex to come in on and clean the extruder to see if there is something wrong there.

The current limit is set to 180% of rated motor current which seems above normal and may cause problems with the motor if it is continued to be run >100% load for extended periods of time.

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