

Tutorial

Norgren Designer 1.4.1

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January 3rd 2006

Tutorial for the Norgren Designer Linear Motor Sizing Tool

Norgren Designer is a sizing tool for the Norgren Linear Motor system. It helps to choose the right linear motor and servo controller for a specific application. The example in this Tutorial will introduce the step by step functions of the Norgren Designer sizing tool.

Why use a design program?

One can pose the question why a design program for linear servo motors is required at all, if the relationships may be simply explained by the formula $F = m \times a$. The reason is that, for exact drive design, certain additional limiting conditions must be considered during calculation:

- The maximum feeding force produced by a linear motor is speed-dependent in practice, and is particularly influenced by the properties of the servo amplifier. As in the case of rotational servomotors, where the maximum torque is reduced with increasing rotation speed, linear motors suffer a reduction in maximum force with increasing speed on account of the counter-voltage.
- Long-stroke movements mostly result in the drives running into a force limit during acceleration and braking phases, whereas otherwise maximum speed is the limiting factor.
- For estimating whether a motor does not overheat under given conditions, the power dissipation for an entire motion cycle must be calculated.

The choice of a suitable motor is an iterative process, as the own mass of that part of the motor in motion is included in the total mass in motion. This means that the design of a drive becomes an iterative process.

From the academic point of view, it can be exceptionally interesting to consider the above-mentioned factors in drive design. For most users on the other hand, it is more sensible to invest time in constructional considerations while leaving mathematical calculations to a program.

Mode of operation of a design program

Using the Norgren Designer motor sizing program is divided into four steps:

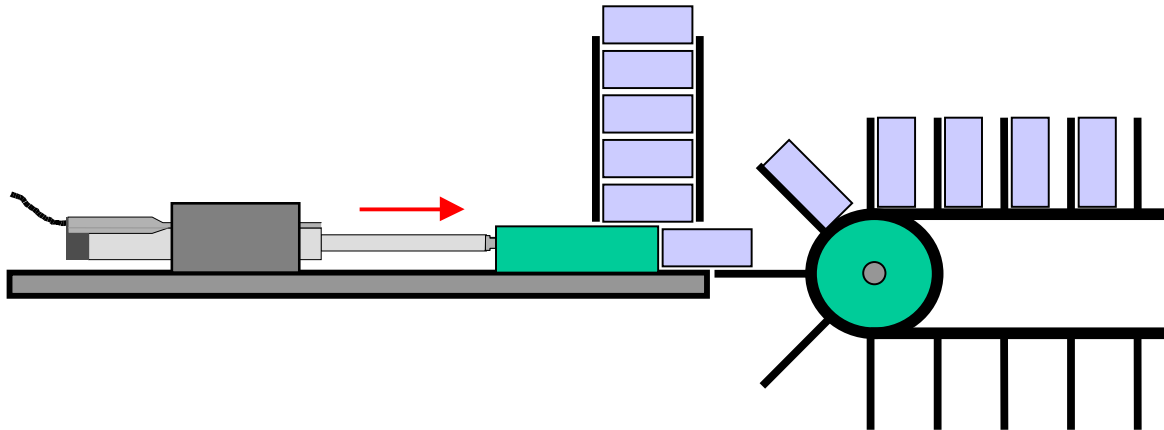
- **Step 1: Start Norgren Designer and input global Data**
- **Step 2: Segmentation of the Motion**
- **Step 3: Checking the Limits**
- **Step 4: Interactive Optimizing**

A design program should not only be used to select a drive, but also to promote an integral way of looking at things: What happens if the load mass can be reduced by 10%? What effect does a reduction or increase of the movement times of individual segments have? Which movement profile is optimal for this application? All these questions can be computed for different solution variants and displayed graphically by a design program in few minutes.

Important: The Norgren Designer is a sizing program that simulates behavior of the Norgren linear motors under static and dynamic load conditions. The Norgren designer offers the constructing engineer fast help in the analysis and optimization of drive technology for a given task. The simulation and calculation comes as close as possible to the behavior of the linear motor in the real application, but is always dependant on the accuracy of the input parameters. It is recommended to discuss and verify the simulation and results with your local Norgren Distributor.

Example 1: Horizontal Movement

In a production line, a pneumatic cylinder pushes 30 products per minute from a stack into a conveyor belt. To increase productivity, a faster second production line will be installed and the pusher has now to handle the products from the two lines. The maximal production rate for the pusher will increase to 82 products per minute.



To handle the 82 products per minute, the minimal cycle time to push one product onto the conveyor belt is 730msec. In order to guarantee gentle product handling (and for dynamic reasons), a Norgren linear motor will replace the pneumatic cylinder.

The mechanical construction should not be changed. The weight of this construction (without the slider of the linear motor weight) is 500g. The product weight itself is 700g.

The questions to answer during the motor sizing are:

- Which type of linear motor may do the job?
- Which size servo controller will be needed to control the motor?
- Do we need additional cooling for the linear motor?
- What's the minimal cycle time for this application?
- What's the minimal cycle when a Series E100 Servo Controller has to be used?

Note: You will find all configurations from this Tutorial in the Norgren Designer folder on your PC (filenames: Tutorial_xx ldc).

Step 1: Start Norgren Designer and input global Data

Starting the Norgren Designer

The last Norgren Designer project will automatically be loaded at start up. To start a new project, click on the “Start new Project” Button. This will reset all parameters to the default values.



Start new Project Button

Define Global Settings according to the Example

In the “Global Settings” window, all motor and construction-specific characteristics must be specified. As at the moment you don’t have any information on the linear motor, we select a motor type with a stroke range slightly bigger than the stroke needed in the application. For the servo controller unit, we select an “NEx000” with a 72 Volts power supply. The cable between controller and motor only has to be defined for longer cables. Its resistance can result in a reduction of the force limit.

As soon as we defined the motion sequence, we will come back to the “Global Settings” Menu in order to select a linear motor and its controller which will be the best for this application.



Global Settings Button

In the “Load” menu, the specification about the mechanical configuration (mounting, friction, zero Positions, etc.) has to be specified according to the construction.

In the example the maximal stroke is 220mm. We choose a start position, which is half of the total stroke, in order to have the motion symmetrical to the Zero Position (ZP) of the linear motor. A symmetrical motion relative to the Zero Position of the linear motor will give the best performance for the motion.

The constant mass of the pusher construction (500g) has to be set in the “Global Settings”. The 700g product mass will be set later in the “Local Settings”, as it has to be considered only for the forward (push) motion. Additional to the mass of the construction, the program will automatically add the mass of the moving part of the motor. In the construction of this application the slider is moving, we have to select “Add Slider mass”.

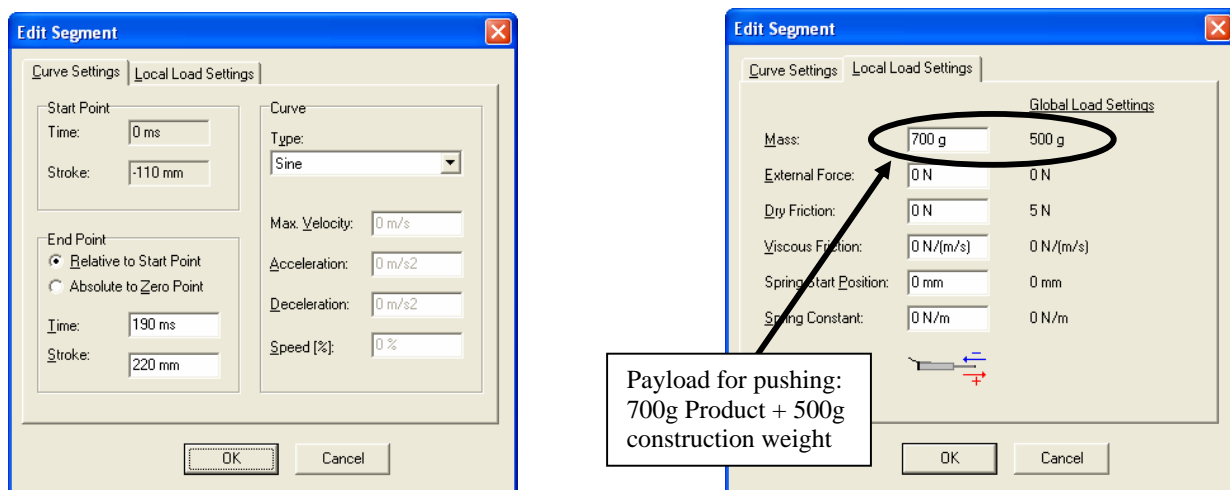
Step 2: Segmentation of the Motion

During the segmentation of movement, the complete motion is subdivided into individual integral movement sections. In our example we can divide the entire motion into three different segments (e.g.: “controlled forward movement”, “fast backward movement”, “Standstill”).

Motion	Stroke	Time	Total Payload
Forward	220mm	190msec	1200g
Backward	-220mm	190msec	500g
Standstill	0 mm	350msec	500g

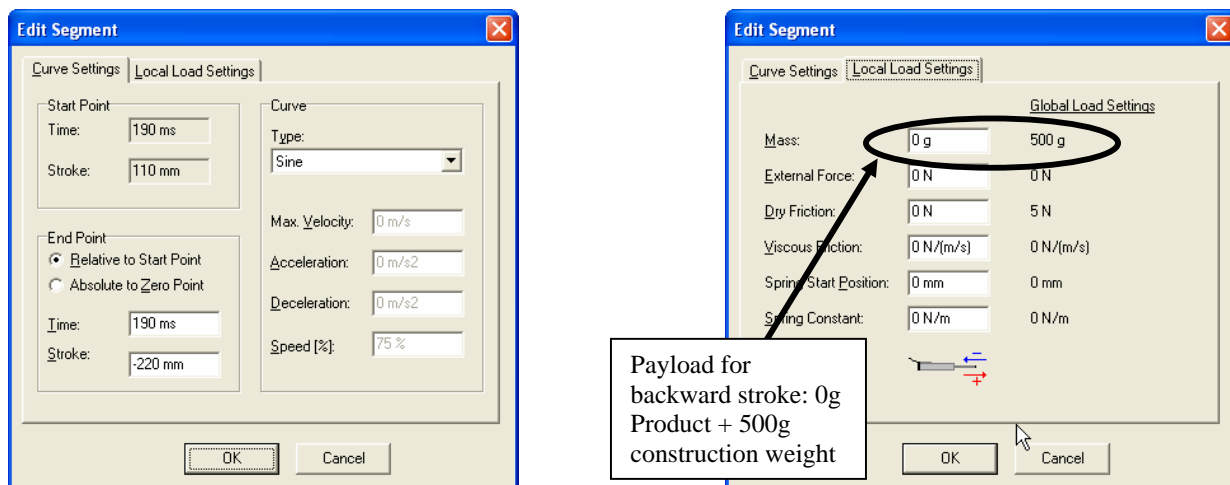
Define the “Forward” Motion

Open the “Edit Segment” window for the first segment of the motion (double click on text “1 Sine”). In the “Curve Settings” window we specify the 220mm motion for the forward movement (pushing). As we have to consider the additional product mass of 700g during pushing (construction and slider mass will be considered automatically).



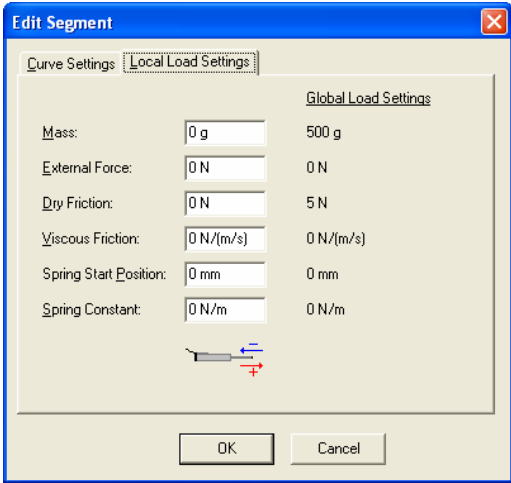
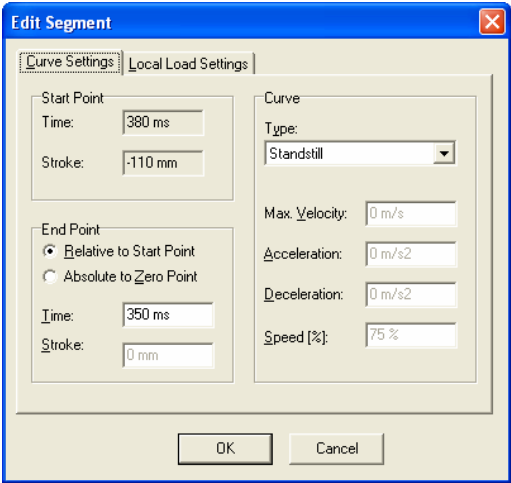
Define the “Backward” motion

Add a new segment for the backward stroke and open the “Edit Segment” window (double click on text “Add new segment”). In the “Curve Settings” window we specify the -220mm motion for the backward movement. We do not have to consider additional mass, as for the backward movement there is now additional payload.

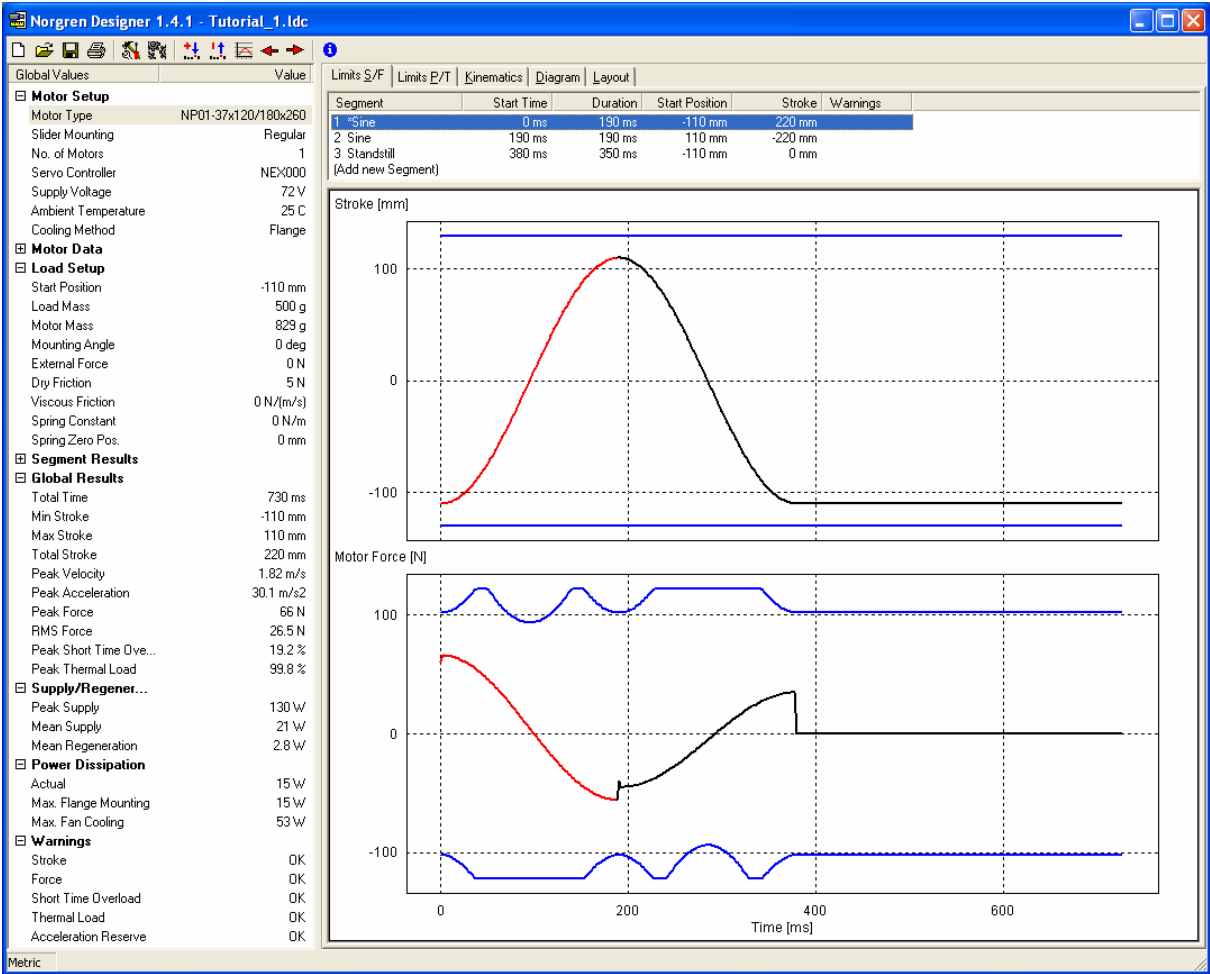


Define the “Standstill” time

Add a new segment for the standstill part of the motion sequence and define the motion according to the screenshots. It is important that you specify the entire cycle of you motion (including standstill time) in order to achieve correct results for RMS force calculation and the thermal load.



After defining the entire motion sequence, the desktop of the Norgren Designer will have the following appearance. If there are any “Local Load Settings” defined in an existing segment, a “*” is prefixed to the corresponding segment name.



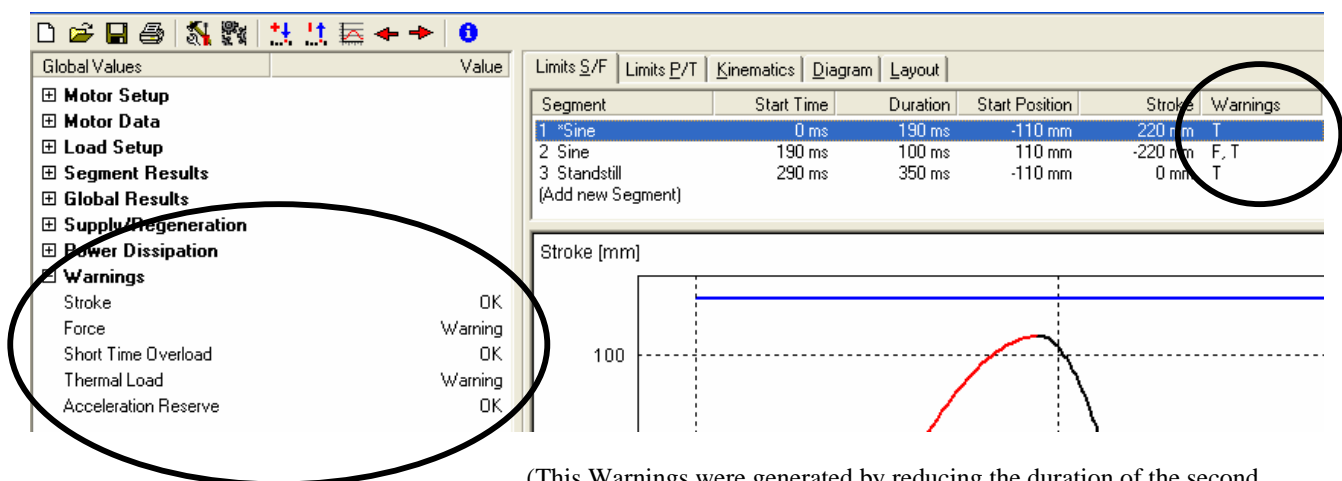
Step 3: Checking the Limits

For the defined application, Norgren Designer calculates diverse physical parameters that are important concerning the design. The most important dynamic parameters are shown as time-dependent values in diagrams (Stroke, Motor Force, Power Dissipation, Short Time Overload Protection Value, Thermal Load, Speed, Acceleration). In the “Global Values” window relevant static parameters as well as peak-, rms- and mean-values of dynamic parameters are shown.

A realisation of the defined application will only be successful, if all of the following dynamic parameters don't exceed their corresponding limits:

Dynamic parameter	Warn flag
Stroke	S
Force	F
Short Time Overload Protection Value	O
Thermal Load	T
Acceleration Reserve at Standstill	A

The limit checks are done by the Norgren Designer. The results of the checks are shown under “Warnings” at the bottom of the “Global Values” window. If a value exceeds the corresponding limit, a “Warning” is displayed. Warn flags in the “Curve Settings” window show, in which segment(s) the corresponding limits are exceeded.



(This Warnings were generated by reducing the duration of the second segment in the example.)

In the “Limits S/F” window, the mechanical parameters “Stroke” and “Force” of the motion with their corresponding limits are shown in time-diagrams. In the “Limits P/T” window, the thermal parameters “Power Dissipation” (without limits), “Short Time Overload Protection Value” and “Thermal Load” with their corresponding limits are shown in time-diagrams.

Stroke Limits

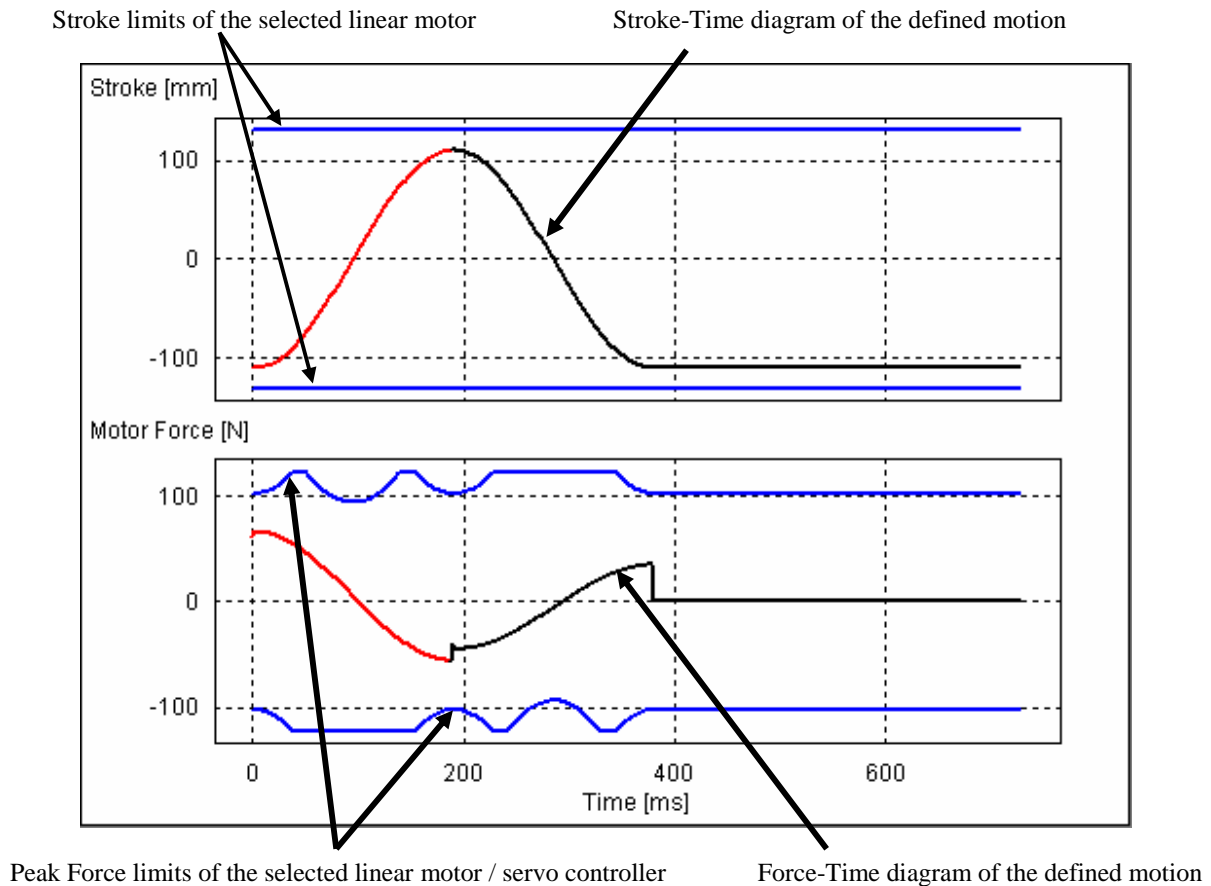
The Stroke and its limits are shown in the upper diagram of the “Limit S/F” window. The graph of the motion (black-red line) has to be within the limits (blue lines) of the selected linear motor.

If the stroke of the motion is too long, you have to select a motor type with a longer maximal stroke. The maximal stroke of the linear motor should be selected as close to the maximum stroke needed in the application in order to minimize the moving mass (slider).

The motion should be symmetrical to the Zero Position (0mm) of the motor. If the motion is not symmetrical you have to adjust the parameter “Start Position” in the “Global Settings” window (see Step 2).

Dynamic Force Limits

The Force diagram shows the dynamic force the linear motor has to produce during the motion (black-red line). You will also find the peak force limits for the selected linear motor (blue lines). If the force the motor has to produce is within the motor limits, the selected motor can perform the requested motion. If the motor force is not within the limits, you have to select another linear motor or servo controller. If the requested force is still not within the limits, extending the execution time in the critical segments or reducing the payload will help to come down with the requested motor force.



Note: Peak force limits of a linear motor depends on the actual position (see stroke force diagram in the data sheets) and on the actual velocity (peak force is decreasing with higher velocities). The peak force may change if another linear motor is selected due to differences in slider mass.

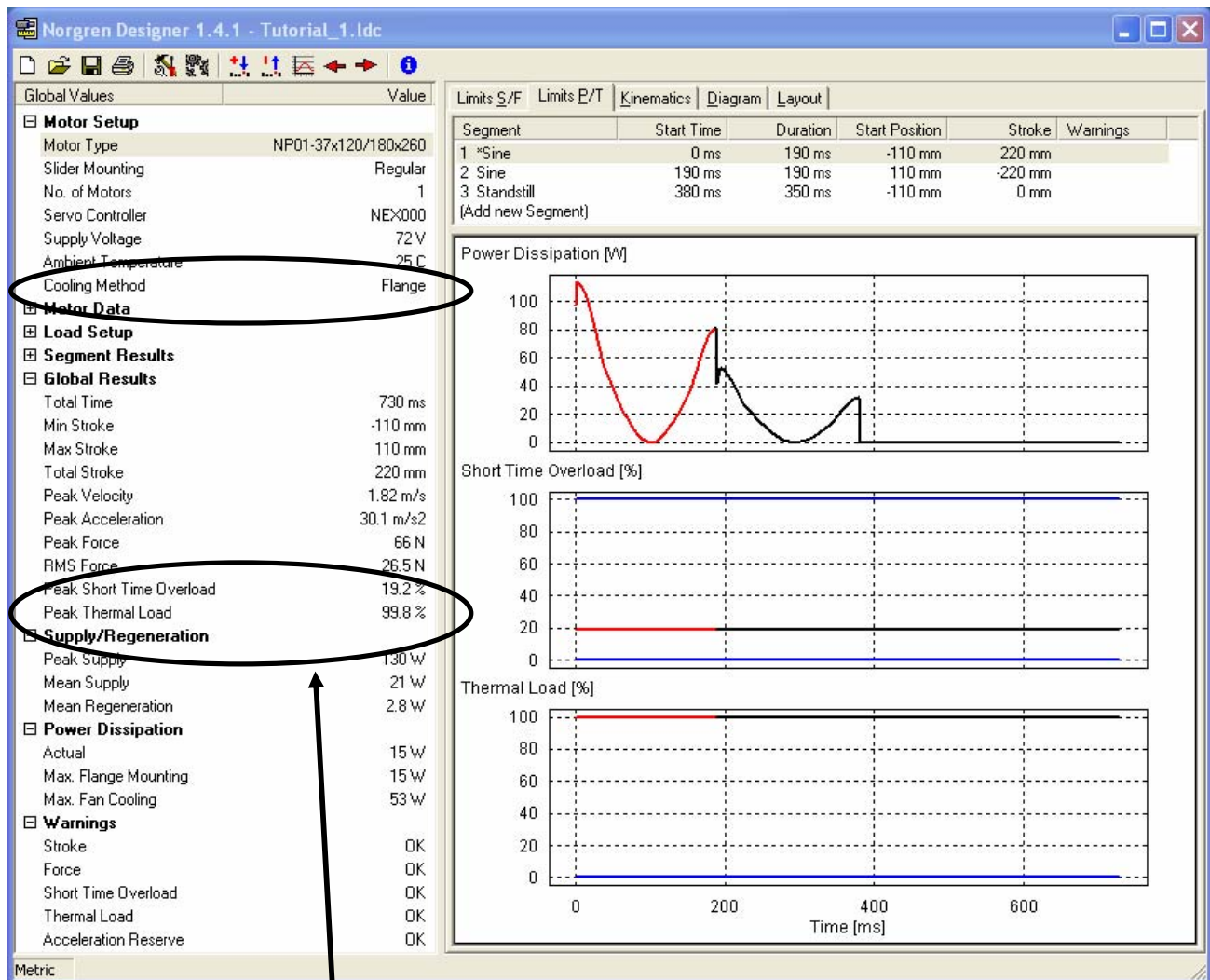
Short Time Overload

The power losses in the motor coils, given by the Power Dissipation, will first heat up the motor winding prior to the other parts of the motor. A short time overload protection mechanism of the Norgren servo controllers prevents the motors from overheating in case of rapid increasing winding temperature due to high power dissipation values. This parameter, the Short Time Overload Protection Value (black-red line) is independent from the motor cooling and approximately constant for short cycle times. The minimal value is 0% and the limit is at 100% (blue lines).

Thermal Load

The power losses in the motor coils, given by the Power Dissipation, will heat up the motor. Depending on the ambient temperature and the cooling method, the corresponding Thermal Load (black-red line) of the motor will result. For short cycle times, the value will approximately be constant. The minimal value is 0% and the limit is at 100% (blue lines). At a Thermal Load of 100%, the thermal hardware protection would turn off the linear motor in the real application (at a case temperature around 65°C). To reduce the thermal load, use the more efficient cooling method ("Fan" in place of "Flange" at "Global Settings") or use a motor with higher continuous force.

Note: The Short Time Overload Protection Value and the Thermal Load are calculated for the thermal steady state.



The Peak Short Time Overload Protection Value is definitely under the limit. The Peak Thermal Load is about equal to the limit, so the linear motor will not overheat in the application. If payload or friction will increase (or cycle time will be reduced), the Thermal Load will increase and exceed the limit. Then, the linear motor has to be mounted on a flange with fan cooling.

Acceleration Reserve at Standstill

This acceleration parameter is the ratio between the “Max Force” of the drive system (servo controller & motor) and the moving mass. It’s a constant value within a segment. It changes from segment to segment with the change of the moving mass. This acceleration value has always to be bigger than the **limit of 10N/kg**. Concerning the example, for the Max Force value of 122N, the maximum moving mass is 12.2kg. In case of an Acceleration Reserve Warning, reduce the load mass or choose another motor/controller so that the Max Force value gets bigger.

Step 4: Interactive Optimizing

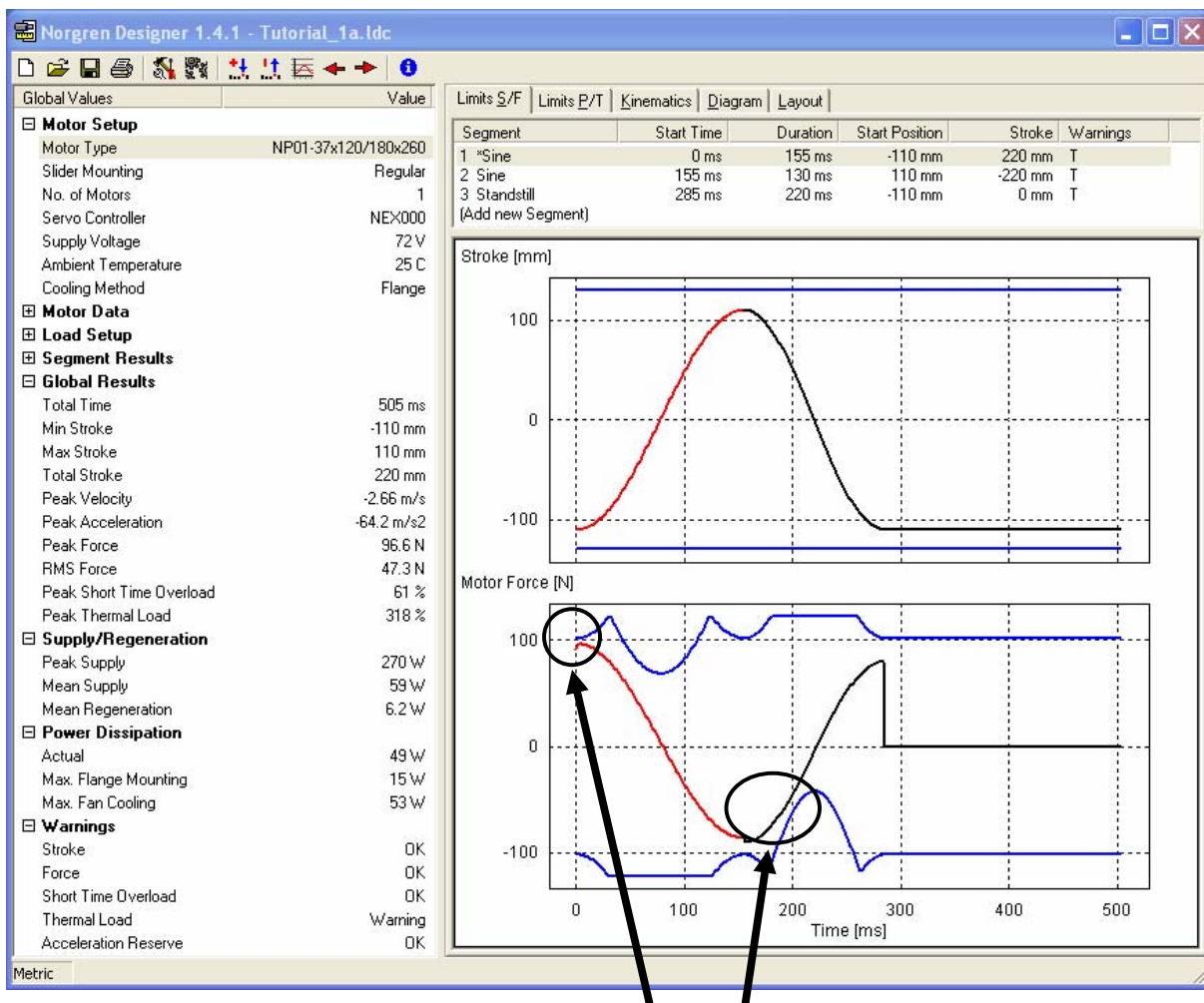
Motor and Servo Controller

Because no Warning was generated, a system with the selected linear motor type NP01-37x120/180x260 and a servo controller of the Series E1000 with 72V supply will be the solution for this project.

In your Norgren Designer folder you will find the file “Tutorial_1.ldc” with the Norgren Designer data for this project.

Optimizing the Cycle Time

If the application requires even faster cycles, the motion times can be minimized for the selected linear motor by reducing the time for the different segments. The time can be reduced as long as the force needed stays within the peak force limits from the selected linear motor.



Limiting parameters for minimal motion time

Minimizing the time in our example shows that the minimal times will be around 155ms for the forward (push) movement and 130ms for the backward movement.

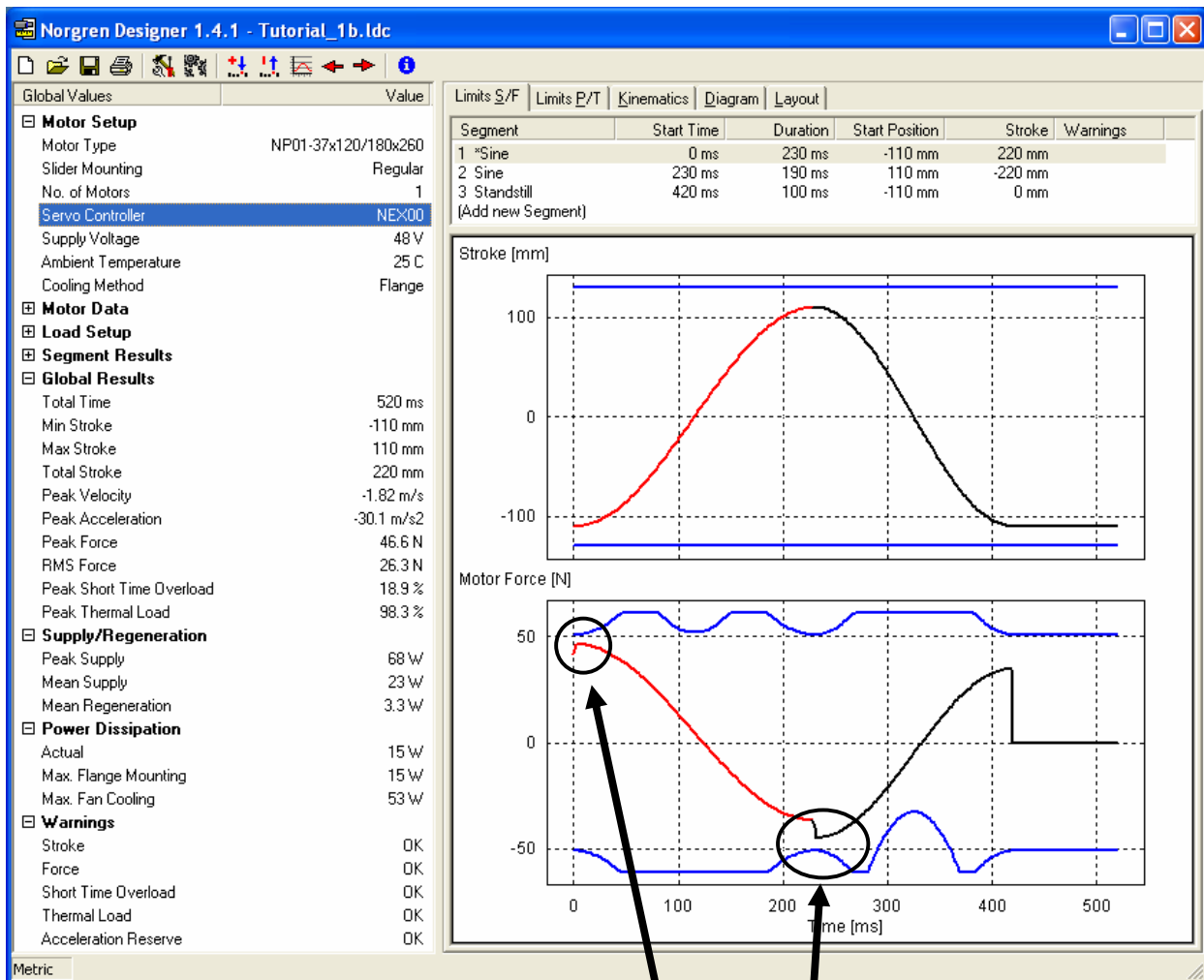
Reducing the time for the forward and backward motion will increase the Peak Thermal Load over the 100%-limit (253%), if the motor is mounted with the standard flange (Cooling Method: Flange). With a change of the Cooling Method to “Fan”, the Peak Thermal Load decreases under its limit to 73.2%.

With the Fan Cooling Method, we can then reduce standstill time to 180ms. This will result in a Peak Thermal Load of 99.9%, which is still within the motor limits.

In your Norgren Designer folder you will find the file “Tutorial_1a.ldc” with the Norgren Designer data for this project.

Using a Servo Controller of the Series E100

If the Application is very cost sensitive and therefore an servo controller of the Series E100 with a 48V supply voltage has to be used, motion time in the segments has to be extended.



For the same linear motor NP01-37x120/180x260 and a Servo Controller Series E100 with 48V Supply voltage, the minimal timings for the motions with would be:

Push: 230ms

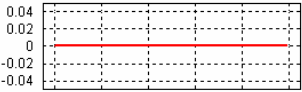
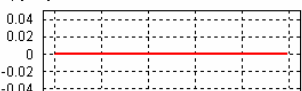
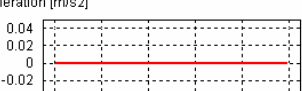
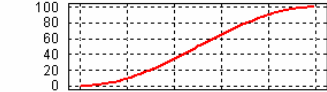
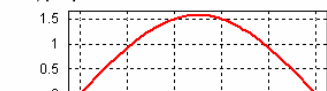
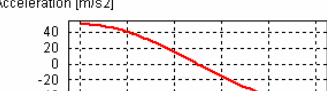
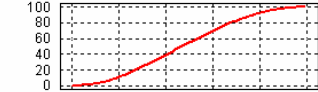
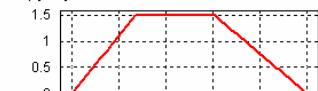
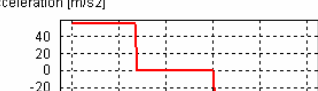
Backward: 190ms

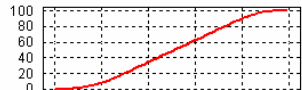
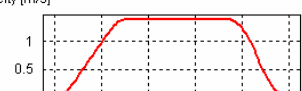
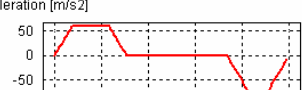
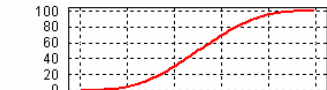
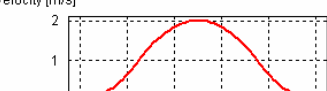
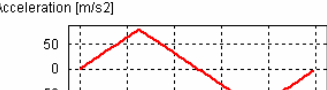
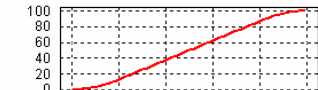
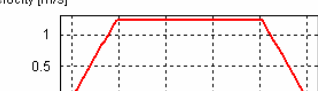
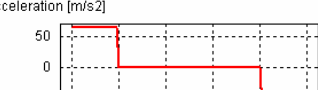
As the slower motions will produce less Power Dissipation, the standstill time can be reduced down to 100ms. With a standstill time of 100ms the Peak Thermal Load is still below 100% (mounted on a standard Flange without fan cooling).

In your Norgren Designer folder you will find the file "Tutorial_1b.ldc" with the Norgren Designer data for this Project.

Example 2: Importing custom Curves

To define the motion profile, Norgren Designer provides different curve types that can be defined by a few parameters:

Standstill	Sine	Point to Point
Parameters: • Time	Parameters: • Time • Stroke	Parameters: • Stroke • Max. velocity • Acceleration • Deceleration
Stroke [mm]  Velocity [m/s]  Acceleration [m/s²] 	Stroke [mm]  Velocity [m/s]  Acceleration [m/s²] 	Stroke [mm]  Velocity [m/s]  Acceleration [m/s²] 

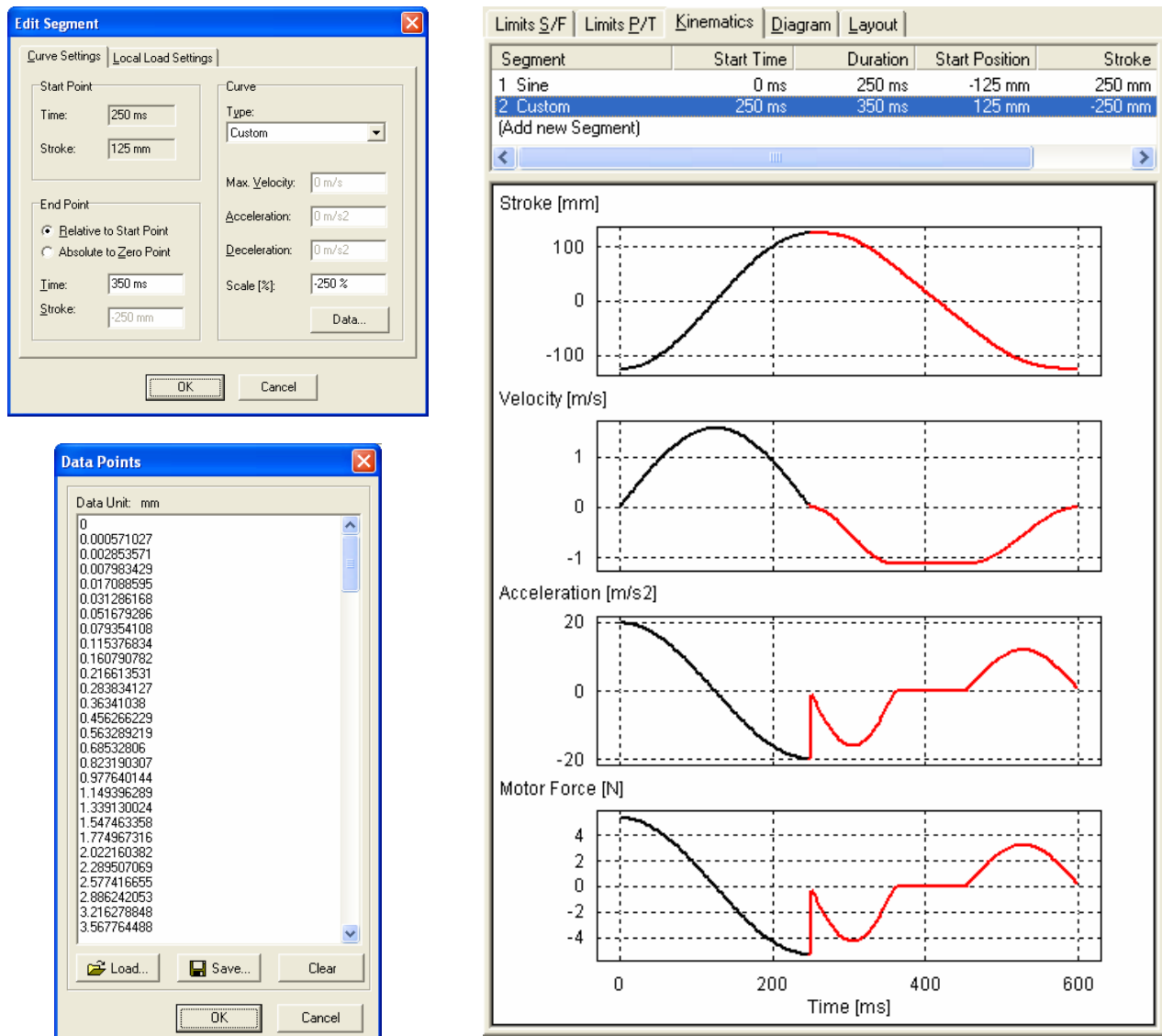
Limited Jerk	Minimal Jerk	MPC ¹⁾
Parameters: • Stroke • Max. velocity • Max. acceleration • Max. deceleration • Jerk	Parameters: • Time • Stroke	Parameters: • Stroke • Speed
Stroke [mm]  Velocity [m/s]  Acceleration [m/s²] 	Stroke [mm]  Velocity [m/s]  Acceleration [m/s²] 	Stroke [mm]  Velocity [m/s]  Acceleration [m/s²] 

1) system-dependent “Point to Point” curve

It is also possible to import a custom motion profile or just a segment of it into Norgren Designer. In order to do that, choose the **“Custom”** curve type. Open the “Data Points” window to define the custom position vector. There are two possibilities to do that:

1. **Load** the *csv-File*, where the numerical values of the position vector are saved.
2. **Copy** the vector from any other program and **paste** it into the Data Points window

The numerical data vector is interpreted in the data unit as it is defined under “Measurement Settings” of Norgren Designer. In the Curve Settings dialog box, the curve time and also a scale factor for the stroke have to be defined.

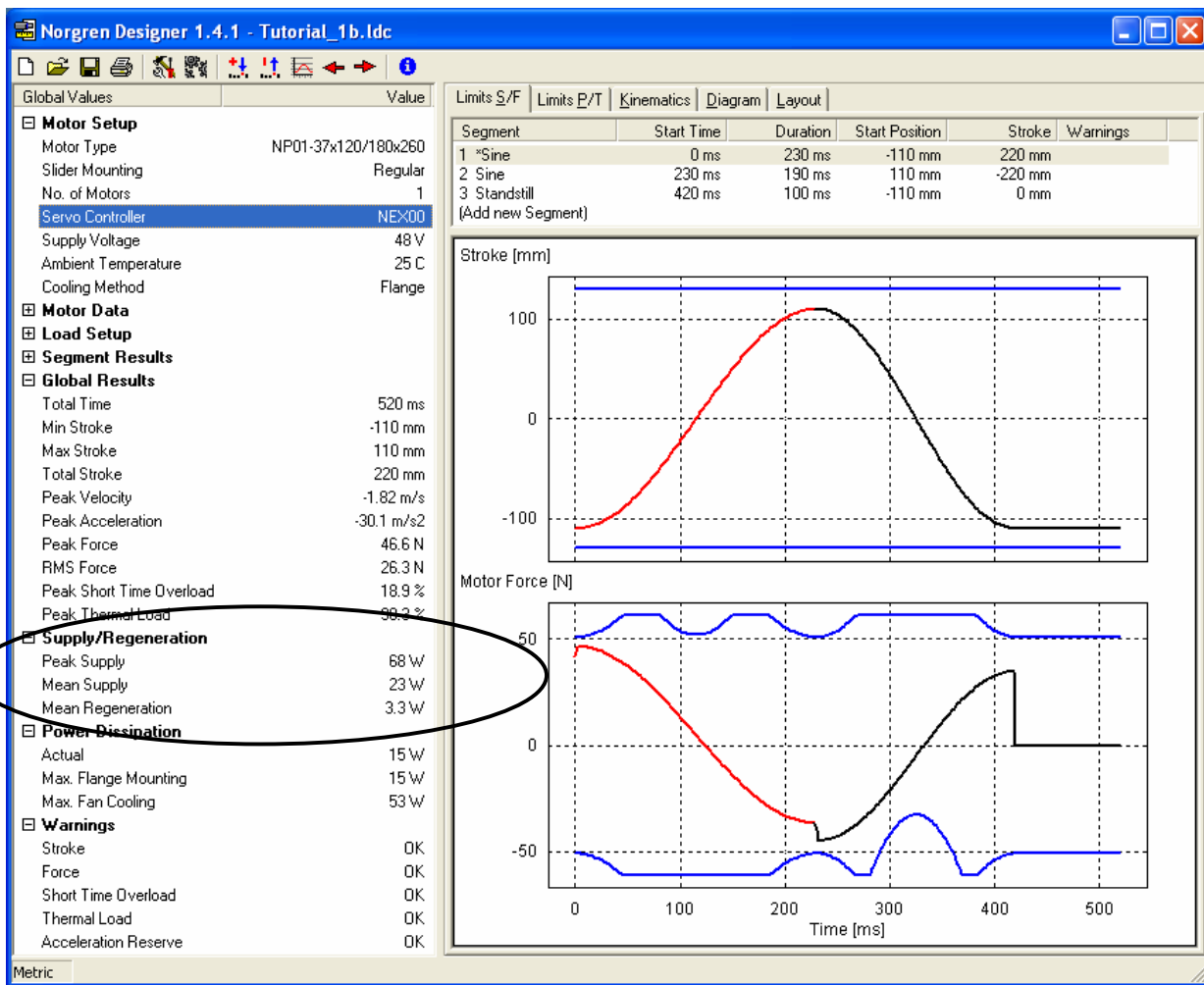


In “Tutorial_2.ldc” a Custom curve (Segment 2) follows on a Sine curve (Segment 1). The data vector of the custom curve was imported (loaded) from the csv-file “Tutorial_2.csv”. With a (negative) Scale value of -250%, the curve data points (forward motion from 0..100mm (in)) are scaled to a backward motion from 0..-250mm, starting at the end of Segment 1.

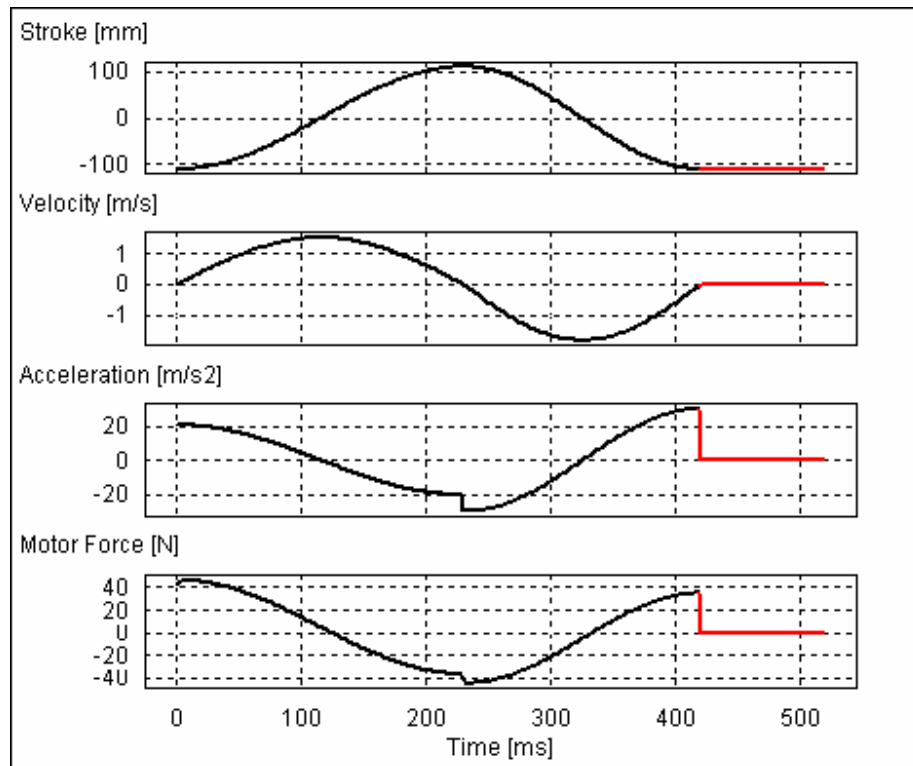
Additional Information

Power information to choose an appropriate power supply for the linear drive system can be found under **Supply/Regeneration**. The Norgren Designer calculates the required electrical power of the motor. The power supply has to deliver the electrical motor power added by the power loss of the controller, whereas the latter makes around up to 10% of the electrical motor power. Depending on the dc link capacitance, the electrical power waveform and the allowed temporary drop of the dc link voltage, the required power of the supply has to be between 110% of the Mean Supply value (absolute minimum) and 110% of the Peak Supply value. To go for sure, use a supply with a power above 110% of the Peak Supply value.

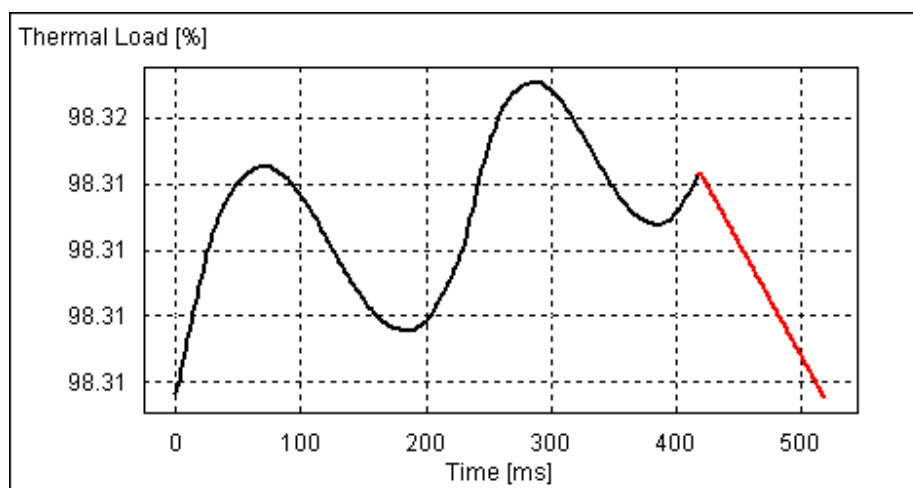
The regeneration power waveform (together with the dc link capacitance and the allowed raise of the dc link voltage) can be used to estimate, whether an external regeneration resistor is necessary. The waveform shows the generated electrical power of the motor during break phases.



The **“Kinematics” window** gives additional information about the motion.

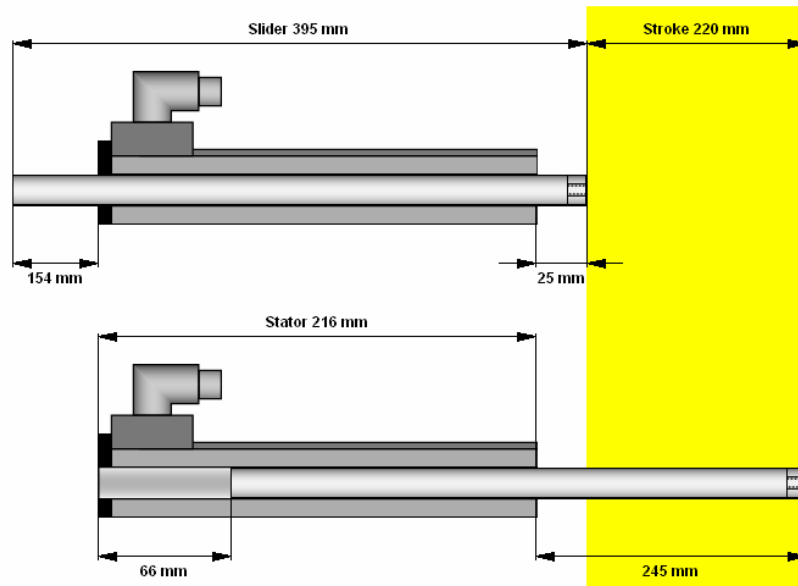


In the **“Diagram” window** can be shown any calculated parameter by double clicking a corresponding characteristic value (min/max-, peak-, rms-, mean- value) in the “Global Values” window.

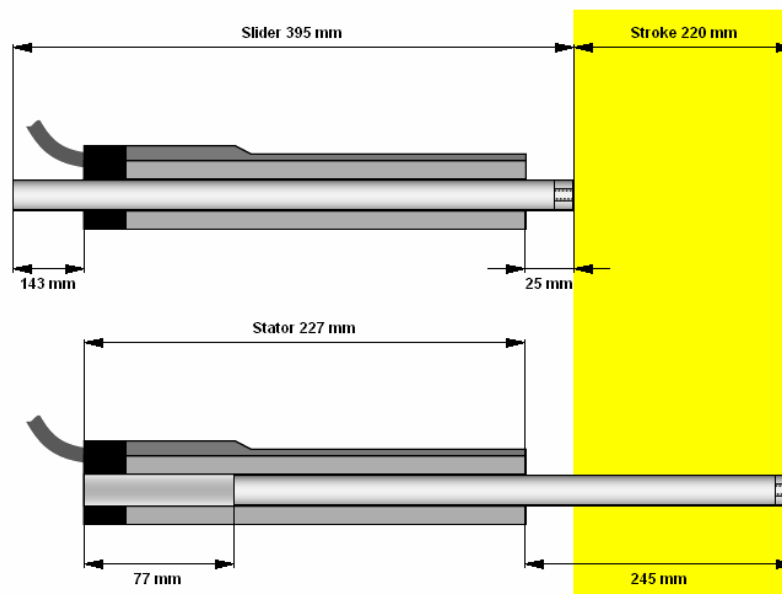


The **“Layout” window** shows you the mechanical dimension of the Linear Motor and the end positions for the different types of motors. The Layout is dependent on the “Layout Motor”-parameter and the “Slider Mounting”-parameter in “Global Settings”.

NP01-37x120/180x260-C



NP01-37x120/180x260(-M)



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