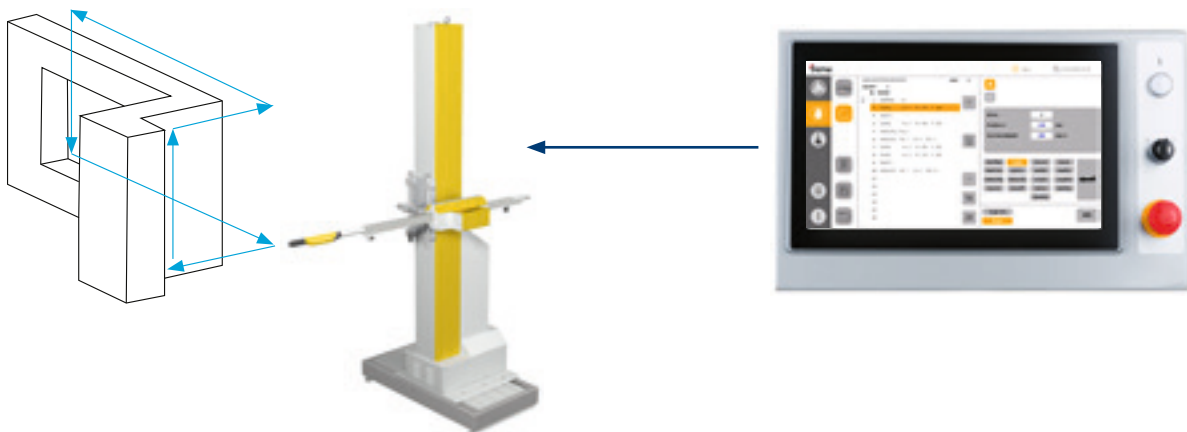# Sequence program

Complex components simply coated

Sequential programming allows serial coating of complex components

The central control unit MagicControl 4.0 with the option sequence program enables individual movement sequences of individual axes or entire stations. The sequence movements of X/Y-, synchronous, infeed or rotation axes for the coating of complex components can be programmed and managed effortlessly directly on the screen. This results in exact coatings and reproducible results. Especially parts with cavities (e.g. baking cavities benefit from this option). The coating guns follow the inner contour of the baking box, this while the conveyor is running. The maximum suspension tolerance in all three directions is +/-6 mm.
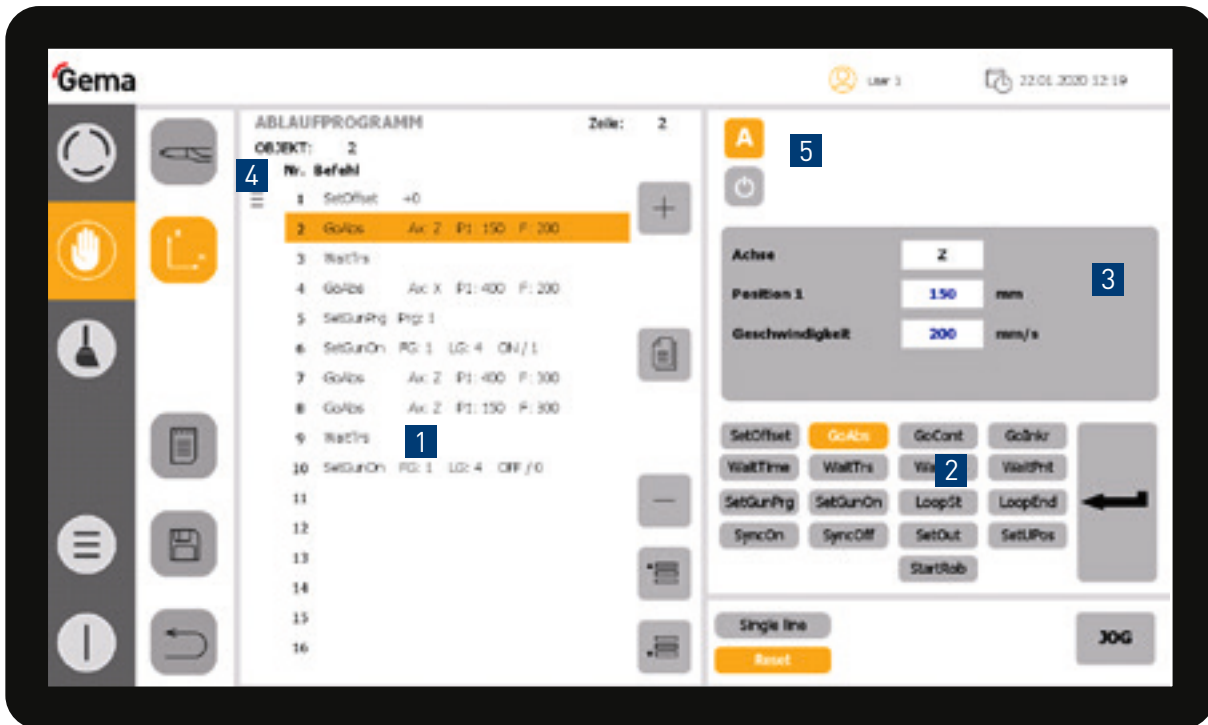

Programming sequential axes movements directly on MagicControl 4.0

Functionality of sequence programs:
- The sequence program represents a self-contained motion sequence of an axis or station, which is started by the operator or a higher-level control system. The sequence can take place once, several times or as an endless loop.
- One or more axes of a station can be moved and positioned simultaneously.
- Dependencies of the individual axes movements are programmed with corresponding commands. Such as: Offset commands, waiting times before or during movement, movement start/stop speeds, coating parameter settings, coating start/stop, number of passes
- 16 logical outputs are assigned to each station that are controlled by the sequence program.
- The positioning of an axis can take place in partial steps, between which, for example, other axes are started. The movement is not interrupted.
- In the sequence program the synchronous movement of the station to the conveyor is started and ended.
- Editor for editing a sequence program

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1   Sequence program and editor
2   Command overview
3   Editing field
4   Scroll bar
5   Start button per station in manual mode

User benefits:
- Automatic coating of complex parts or internal coating of hollow bodies such as baking cavaties
- Individual determination of the axes movement
- Coating optimization and influence on layer thickness
- Programing, storage and recall of individual application programs
- Easy to use editor for creating a sequence program