



Spett.le

R.E.M. SRL

Indirizzo: VIA FERRUCCIA 16/A

Comune: PATRICA 03010 (FR)

P. IVA IT02240470605

Milano, 24.06.2022

Rif. 22.21452

Analisi Tecnica 21.500.0529

Nuovo Piano Nazionale Transizione 4.0

Legge n. 232 dell'11.12.2016

Legge n. 205 del 27.12.2017

Legge n. 160 del 27.12.2019

Legge n. 178 del 30.12.2020

Oggetto:

N. 1 FORNO DI COTTURA TECFLAM MOD. 28

modello 21.21486_90

Serial number 21.21486.001

**Forno di cottura per impregnazione di componenti di
motori elettrici**



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Società: R.E.M. SRL



Indirizzo Sede Legale: VIA FERRUCCIA 16/A – PATRICA (FR)

Indirizzo PEC: rem-motori@messaggipec.it

Numero REA: FR - 138995

P. IVA: 02240470605

Forma giuridica: SOCIETA' A RESPONSABILITA' LIMITATA

Codice ATECO: 33.14 - Riparazione e manutenzione di apparecchiature elettriche (esclusi gli elettrodomestici)

Indirizzo di installazione: VIA FERRUCCIA 16/A – PATRICA (FR)

Reparto di installazione: PRODUZIONE

Bene Materiale: FORNO TECFLAM MOD. 28 DI COTTURA PER IMPREGNAZIONE DI COMPONENTI DI MOTORI ELETTRICI

Sistema messo in funzione nel: 2021

Ispezione in data: 09/06/2022

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Beni funzionali alla trasformazione tecnologica e digitale delle imprese

Secondo il modello << Nuovo Piano Nazionale Transizione 4.0 >>

Allegato A annesso alla Legge 11 dicembre 2016, n. 232 e s.m.i.

*** **

Beni strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti

Sommario:

- 1 Termini e definizioni**
- 2 Breve descrizione del bene inserito nel ciclo produttivo**
- 3 Classificazione del bene**
- 4 Individuazione del costo del bene e dei suoi accessori**
- 5 Esame possesso delle Caratteristiche Obbligatorie del bene in esame**
- 6 Control Check**
 - 6.1 *Check List 1 – Beni Allegato A strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti (Gruppo I)*
- 7 Conclusioni**

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1 Termini e definizioni

Ai fini della presente Analisi Tecnica si applicano i termini e le definizioni riportate al paragrafo 3 del rapporto tecnico UNI/TR 11749:2020.

2 Breve descrizione del bene inserito nel ciclo produttivo

Il forno Tecflam Mod. 28 è un forno di cottura per impregnazione di componenti di motori elettrici utilizzato dall'azienda nell'ambito della produzione di motori.

Trattasi dunque di forno utilizzabile in conformità alla classificazione 1.03 **“Macchine e impianti per la realizzazione di prodotti mediante la trasformazione dei metalli e delle materie prime”**.

DATI IDENTIFICATIVI DELLA MACCHINA

Denominazione del costruttore: TECFLAM SRL VIA CURIEL 3 42025 (CONTE TEGGE) CAVRIAGO (RE)

Denominazione commerciale: FORNO DI COTTURA MOD. 28

Tipologia di Macchina: FORNO DI COTTURA PER IMPREGNAZIONE DI COMPONENTI DI MOTORI ELETTRICI

Configurazione: Macchina comprensiva di: NESSUN ACCESSORIO (es. nastro di trasporto in ingresso e in uscita, pesatrice, dispositivo hot melt, sistema a raggi x, marcatore, ecc.)

Numero di matricola: 21.21486.001 Anno di fabbricazione: 2021

Principali funzionalità svolte dalla macchina, prendendo spunto dalle brochure e dalle schede tecniche.

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Caratteristiche tecniche:

- Costruzione modulare con pannelli verniciati a polvere ed imbullonati;
- Porta registrabile con guarnizione in cordone di fibra ceramica rinforzata con fibra di vetro;
- Isolamento termico con lana minerale ad alta densità ricoperta con lamierino zincato;
- Pavimento isolato con pannelli rigidi di fibra ceramica;
- Carrello munito di ruote per la movimentazione ed il carico dei motori da trattare con vasca di raccolta gocce amovibile;
- Rotaie per scorrimento carrello nel pavimento;
- Gruppo termico costituito da resistenze elettriche corazzate e ventilatore di ricircolo ad alta efficienza posizionato nella parte posteriore del forno;
- Valvola di scarico aria servo-comandata;
- Controllo del gruppo termico tramite termoregolatore collegato a sonda di temperatura installata sulla parete del forno;
- Termostato di sicurezza elettronico sulla mandata dell'aria calda;
- Pressostato differenziale per l'inserimento delle resistenze solo dopo l'avviamento del ventilatore di ricircolo;
- Quadro elettrico in esecuzione IP 55 con interruttore generale, pulsante di emergenza e strumento di controllo del processo.

L'avviamento del ventilatore di ricircolo è comandato dal quadro elettrico; successivamente si procede all'inserimento delle resistenze.

La durata del ciclo è controllata da un controllore di marca Gefran con interfaccia operatore grafica touch con display 7".

Al completamento della durata del ciclo le resistenze vengono automaticamente disinserite mentre il ventilatore continua ad insufflare aria fino a quando la temperatura non è scesa al di sotto di un limite impostabile; in questa fase la valvola di scarico aria è aperta per favorire il raffreddamento.

Durante il funzionamento la valvola di scarico, normalmente chiusa, può essere aperta per un tempo impostabile.

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È prevista la possibilità di effettuare un prelavaggio, con le resistenze escluse, prima di dar corso al riscaldamento.

Di seguito le foto del macchinario:



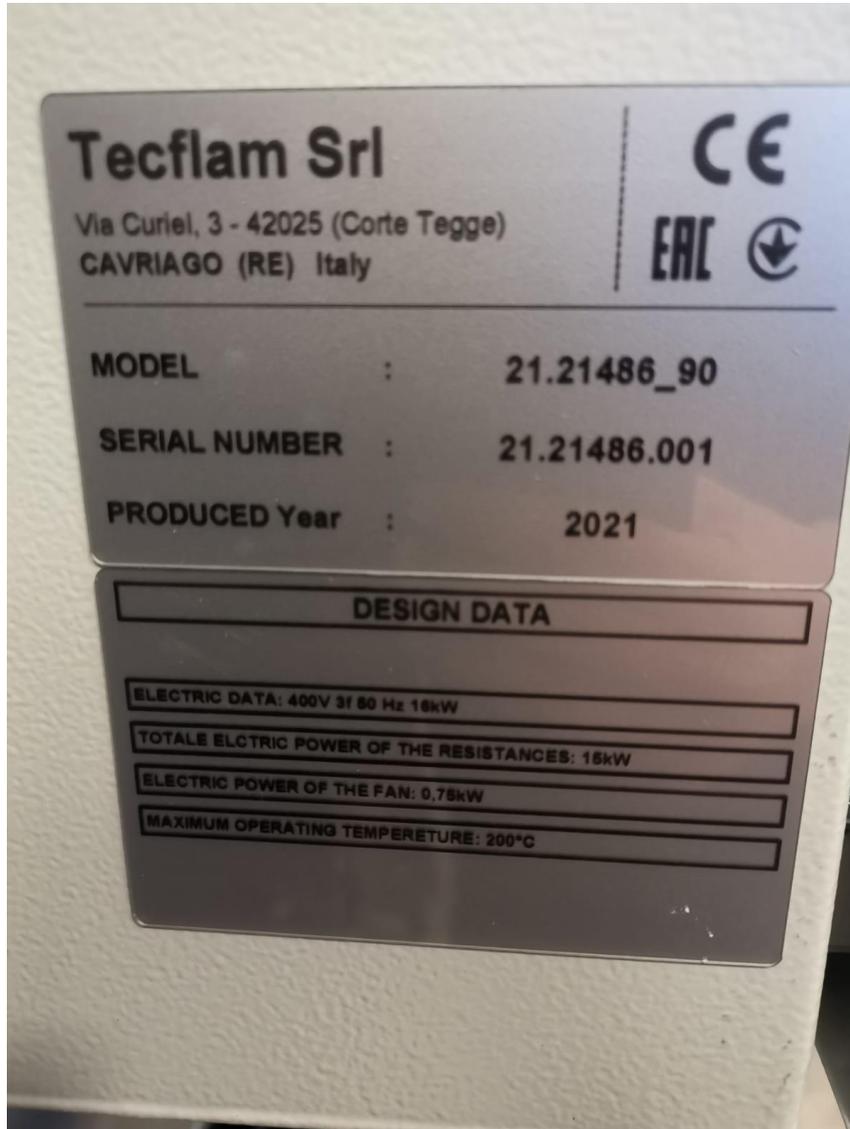
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3 Classificazione del bene

Al fine della classificazione, il bene risulta essere dotato di diverse "Tecnologie abilitanti Industria 4.0", ovvero nuove tecnologie produttive per migliorare le condizioni di lavoro, i modelli di business, la produttività e la qualità produttiva degli impianti, quali:

N°	Tecnologia	Descrizione	
1	<i>Advanced Manufacturing Solution</i>	Robot collaborativi interconnessi e rapidamente programmabili	<input type="checkbox"/>
2	<i>Additive Manufacturing</i>	Stampanti in 3D connesse a software di sviluppo digitali	<input type="checkbox"/>
3	<i>Augmented Reality</i>	Realtà aumentata a supporto dei processi produttivi	<input type="checkbox"/>
4	<i>Simulation</i>	Simulazione tra macchine interconnesse per ottimizzare i processi	<input type="checkbox"/>
5	<i>Horizontal/Vertical Integration</i>	Integrazione informazioni lungo la catena del valore dal fornitore al consumatore	<input type="checkbox"/>
6	<i>Industrial Internet</i>	Comunicazione multidirezionale tra processi produttivi e prodotti	<input type="checkbox"/>
7	<i>Cloud</i>	Gestione di elevate quantità di dati su sistemi aperti	<input type="checkbox"/>
8	<i>Cyber-security</i>	Sicurezza durante le operazioni in rete e su sistemi aperti	<input type="checkbox"/>
9	<i>Big Data and Analytics</i>	Analisi di un'ampia base dati per ottimizzare prodotti e processi produttivi	<input type="checkbox"/>
10	<i>Altro</i>	Automazione dei processi attraverso l'applicazione dei concetti di robotica ed altre tecnologie abilitanti	<input checked="" type="checkbox"/>

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Tecnologie per la trasmissione e per l'elaborazione
dei dati raccolti dalle macchine durante le
lavorazioni programmate

La macchina FORNO TECFLAM MOD. 28 soddisfa il criterio dell'Allegato A della Legge 11 dicembre 2016, n. 232 in quanto trattasi di bene strumentale il cui funzionamento è controllato da sistemi computerizzati e gestito tramite opportuni sensori e azionamenti, ovvero di un forno di cottura (denominato come FORNO DI ESSICCAZIONE) destinato a cottura per ottenimento dell'impregnazione di componenti di motori elettrici utilizzato dall'azienda nell'ambito della produzione di motori.

In riepilogo:

sulla base di tali valutazioni, si ritiene, che il cespite in parola, sia assimilabile, agli effetti della disciplina delle agevolazioni previste per il piano Industria 4.0 a beni del primo gruppo, Voce 3 **“Macchine e impianti per la realizzazione di prodotti mediante la trasformazione dei metalli e delle materie prime.** In questo caso si intendono macchine e impianti impiegati nell'industria manifatturiera discreta, nell'industria di processo e in quella di trasformazione che devono essere dotati di proprietà di riconfigurabilità, di flessibilità. La voce in elenco è applicabile indipendentemente dal prodotto (o semilavorato) realizzato o trasformato o trattato e dal relativo ciclo tecnologico e indipendentemente dal tipo di realizzazione o trasformazione o trattamento (meccanico, chimico, fisico, ecc) indotto sul prodotto o semilavorato. Per impianto o porzione di impianto si intende un insieme di macchine connesse fisicamente fra loro anche se ogni macchina o attrezzatura funziona in maniera indipendente. L'impianto gode del beneficio fiscale anche nel caso in cui i singoli componenti provengano da fornitori diversi”.

4 Individuazione del costo del bene e dei suoi accessori

Sulla base della documentazione prodotta e delle dichiarazioni rese dall'impresa risulta che:

Il valore complessivo dell'investimento è pari a € 15.600,00 + iva.

Cfr. fattura n. 350 del 27/05/2021 – n. 901 del 07/12/2021 – n. 921 del 10.12.2021 emessa da TECFLAM SRL (vedi Allegato n. 1).

L'impresa R.E.M. SRL dichiara inoltre che intende considerare quali componenti e accessori del bene i seguenti elementi:

Nessuno

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5 Esame possesso delle Caratteristiche Richieste del bene in esame

Si esaminano di seguito le caratteristiche del bene al fine di accertare il rispetto dei Requisiti Obbligatori.

Il bene risulta dotato nel complesso delle seguenti caratteristiche:

a) Controllo per mezzo di CNC (Computer Numerical Control) e/o PLC (Programmable Logic Controller)

Il forno Tecflam Mod. 28 è un forno di cottura per impregnazione di componenti di motori elettrici utilizzato dall'azienda nell'ambito della produzione di motori.

Di seguito le foto del quadro elettrico contenente il PLC e del pannello touchscreen:

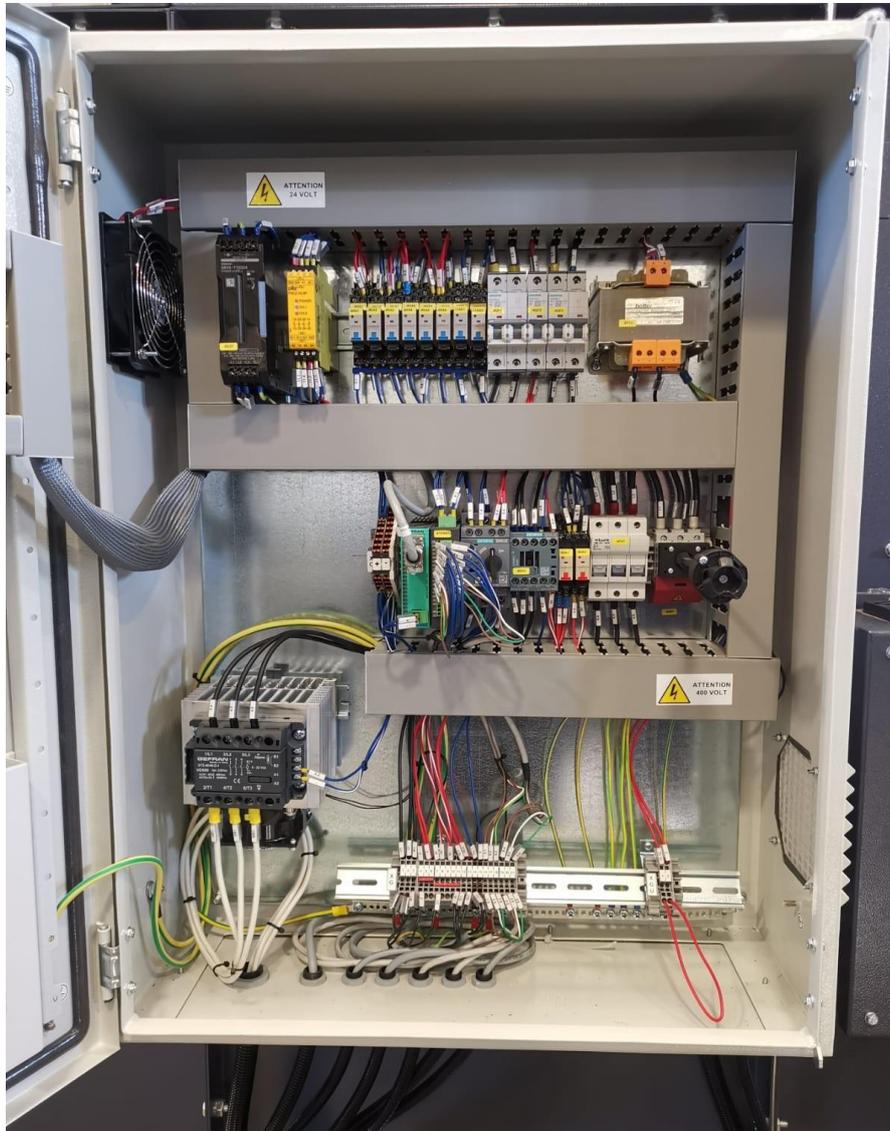
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Il PLC controlla il funzionamento del forno e consente di modificare ed impostare, sia in locale che in remoto mediante idonea interconnessione a gestionale di produzione, i dati seguenti:

1. Ricette di lavoro
2. la rampa di salita della temperatura in camera di trattamento
3. temperatura di prelavaggio
4. tempo prelavaggio
5. temperatura fase di trattamento 1
6. tempo fase trattamento 1

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7. temperatura fase di trattamento 2
8. tempo fase trattamento 2

Il PLC registra inoltre le ore di lavoro totali del forno ed il numero totale di cicli del forno. L'unità di controllo consente di impostare le "ricette" di trattamento, di salvarle ed avviare i cicli di produzione. Consente inoltre di monitorare costantemente lo stato del forno, le valvole, le bobine, i cicli di lavoro; permette di rilevare le anomalie e gli allarmi, segnalandoli repentinamente.

Il PLC si interfaccia con l'operatore mediante display a colori a bordo macchina che ne consente un utilizzo semplice ed efficiente. Il PLC risulta connesso alla rete ethernet aziendale e si interfaccia con il gestionale di produzione. Risulta altresì accessibile in remoto per manutenzione ed assistenza, oltre che per monitoraggio continuo.

Approfondimento

La funzione Data Logger, in unione con il Real Time Clock (RTC, orologio con batteria tampone ricaricabile) permette di memorizzare i dati di processo, i segnali IN/OUT e lo stato degli allarmi in un file aperto (formato .CSV) o cifrato. La frequenza minima di campionamento dei dati è 1 secondo. I file archiviati possono essere poi esportati dal regolatore tramite chiavetta USB o rete Ethernet. L'opzione rapporto del lotto di produzione (Batch Report) permette di associare questi dati a uno specifico lotto prodotto, per poterli poi usare nei rapporti di produzione e di qualità. Per facilitare la gestione di tutti i dati del Data Logger e dei rapporti del lotto di produzione è disponibile un'apposita applicazione per PC (Report Utility), che permette di copiare e cancellare via rete Ethernet i file tra il regolatore e un PC, sia automaticamente a scadenze temporali configurabili sia manualmente dietro comando dell'operatore. I dati salvati sul PC possono essere poi visualizzati in formato grafico o su un foglio di calcolo (tipo Excel), oppure esportati come file CSV o PDF. Le ricette, facilmente richiamabili dall'operatore, possono essere di due tipi: ricette del costruttore OEM, che contengono i parametri di allestimento del macchinario, e ricette di produzione, che contengono i parametri di impostazione di una singola produzione (programma di profilo, passi logici, funzioni matematiche). Le ricette si possono trasferire facilmente tra regolatori diversi tramite chiavetta USB o rete Ethernet. I regolatori offrono una diagnostica completa (rottura o errato collegamento della sonda, rottura totale o parziale del carico, anomalie dell'anello di regolazione), che aiuta l'operatore in caso di anomalie del macchinario o del processo gestiti. Tutti gli allarmi del regolatore sono memorizzati internamente e visualizzabili come Allarmi attivi e Allarmi storici. Per ogni allarme storico vengono visualizzati il messaggio relativo e la data e ora dei vari stati (allarme attivo, ACK, e allarme disattivo). Il parametro ACK, configurabile per ogni allarme, permette di essere certi che l'allarme attivo sia stato preso in considerazione dall'operatore.

Principali caratteristiche del regolatore 3850T:

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- Interfaccia operatore con Display Touch Screen a colori, 7"
- Fino a 16 loop di controllo PID
- Controlli PID in cascata, di rapporto, per Valvole
- Programmatore di profili con rampe e mantenimenti; sincrono e asincrono
- Fino a 250 programmi da 50 segmenti
- 3 livelli di accesso per utente protetti da password
- Contatore di energia (kWh)
- Operazioni logiche configurabili
- Funzioni matematiche configurabili
- Data Log con Real Time Clock
- Gestione dei report dei lotti di produzione (Batch Report)
- Trascrizione su file in chiaro (CSV) o criptati per Data-Log e lotti di produzione
- Configurazione di pagine personalizzate
- Gestione degli allarmi attivi e storici
- USB per esportazione dati e clonazione parametri
- Tuning evoluto dei parametri di regolazione
- Segnali di I/O analogici e digitali configurabili
- Scambio dati HMI/SCADA/PLC tramite Ethernet Modbus TCP
- Selezione della lingua per i messaggi

Di seguito una foto esemplificativa del display acceso:

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Di seguito una schermata, acquisita da PC connesso in remoto con il forno, con evidenza delle funzionalità dello stesso:

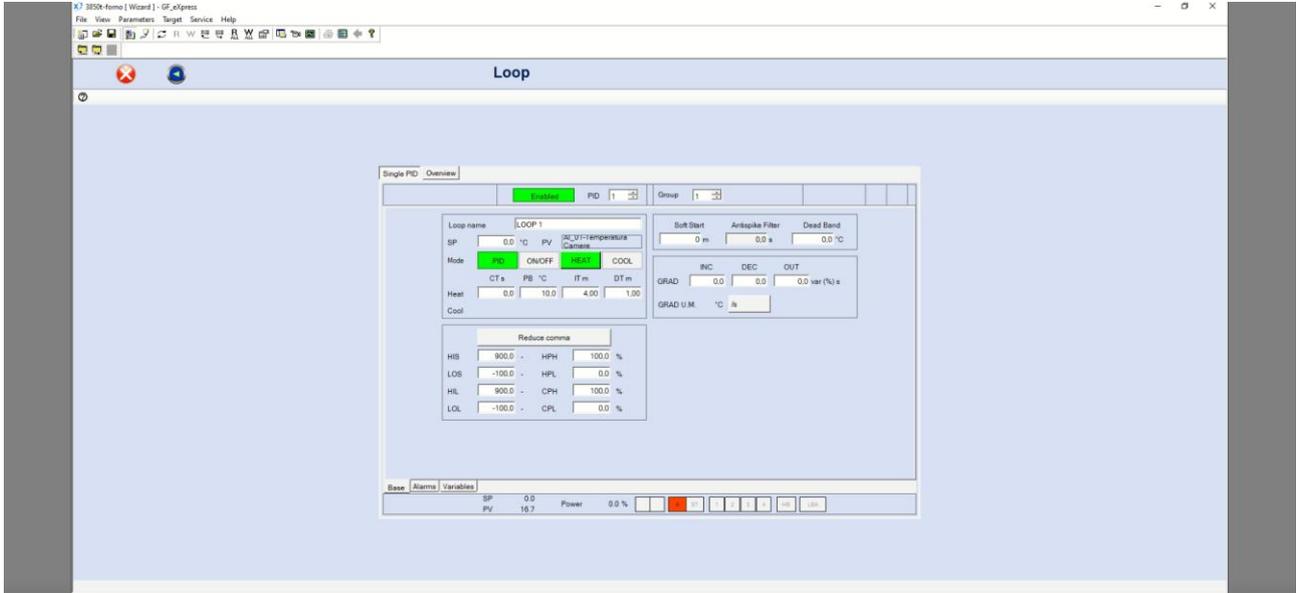
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MENÙ INGRESSO



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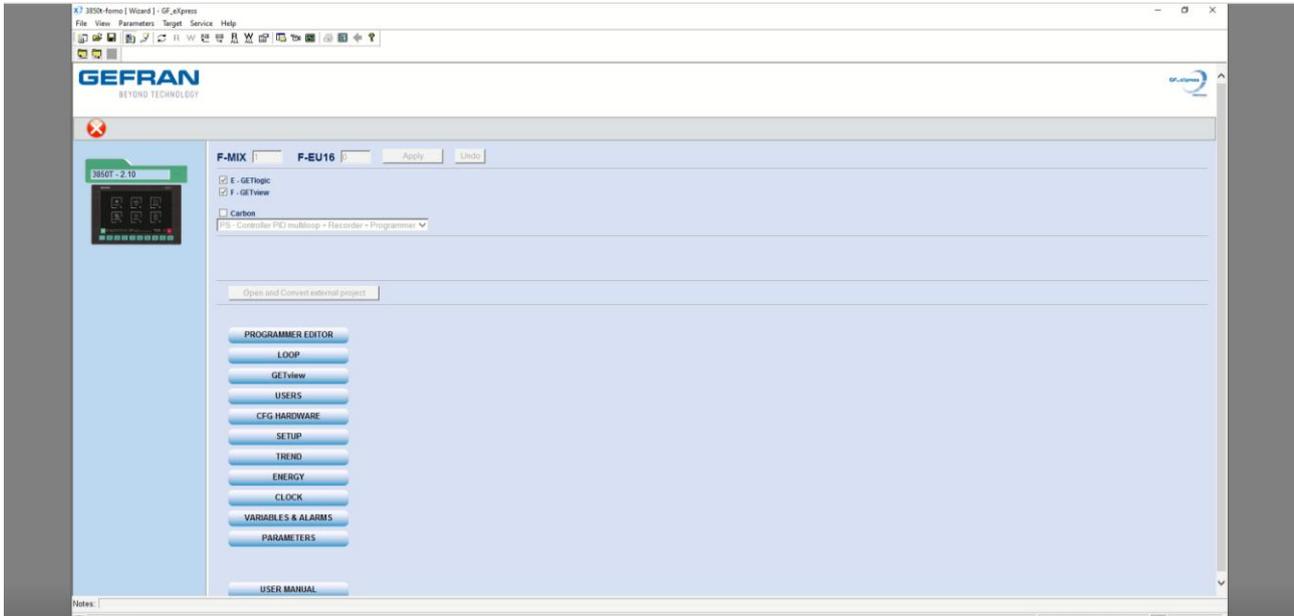
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MENÙ PROGRAMMAZIONE



Il bene soddisfa il requisito obbligatorio RO1.

b) Interconnessione ai sistemi informatici di fabbrica con caricamento da remoto di istruzioni e/o part program.

Il forno Tecflam Mod. 28 è un forno di cottura per impregnazione di componenti di motori elettrici utilizzato dall'azienda nell'ambito della produzione di motori. Il suo PLC comunica mediante protocollo ModBus TCP-IP con il PLC master Siemens Step7 che gestisce la comunicazione bidirezionale tra l'azienda e gli apparati di produzione. A sua volta il PLC Master è connesso alla rete ethernet aziendale. Tramite tale strutturazione è possibile inviare part program al forno Tecflam Mod. 28 e ricevere i dati di produzione grazie all'interfacciamento con la piattaforma appositamente creata su Sw TIA PORTAL v. 16, che opera con linguaggio MySql express 2018. Tale piattaforma, appositamente creata in azienda per l'automazione dei processi, funge da gestionale di produzione, consentendo di inviare i dati al forno Mod. 28 (ricette e parametri di lavoro); al contempo essa

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ricevere e rielabora i dati di produzione con lo scopo di attuare una perfetta integrazione automatizzata tra macchina ed azienda.

La comunicazione messa in atto tramite tale architettura informatica è di tipo bidirezionale, rendendo inoltre possibile monitorare costantemente l'attività e ricevere segnalazioni di anomalie ed allarmi.

Il sistema consente di:

- Creare un ordine di lavoro da remoto da parte del Responsabile di officina
- Tale ordine di lavoro viene associato ad un numero commessa che lo identifica univocamente
- A tale ordine di lavoro viene associata una ricetta di lavoro (mediante impostazioni di set di parametri che governeranno il processo)
- L'ordine di lavoro, associato alla commessa ed al processo, è visualizzato sulla macchina
- La macchina fa partire il ciclo di lavoro, dietro la supervisione del Responsabile di Produzione
- Il sistema è predisposto per la verifica di anomalie circa la correttezza di avvio dei cicli nel rispetto dell'Odl inviato. Tale aspetto risulta fondamentale in quanto un eventuale errore di sistema potrebbe produrre distruzione del prodotto inserito nel forno o altri rischi correlati.
- La macchina termina il ciclo
- Il sistema consente di monitorare costantemente i dati real time di lavoro (set parametri, tempo di avvio, numero cicli, etc.)
- Il PLC trasmette al PLC master ed al gestionale di produzione i dati di lavoro che vengono elaborati ed archiviati nel server aziendale
- In qualsiasi momento è possibile verificare parametri, date e orari, oltre che ricette e impostazioni di ogni commessa registrata e univocamente identificata mediante numero specifico.

Di seguito una sintesi dei dati in Ingresso ed in Uscita:

Dati in ingresso:

1. Ricette di lavoro
2. la rampa di salita della temperatura in camera di trattamento
3. temperatura di prelavaggio
4. tempo prelavaggio
5. temperatura fase di trattamento 1
6. tempo fase trattamento 1
7. temperatura fase di trattamento 2

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8. tempo fase trattamento 2

Dati in uscita

- monitoraggio costante dello stato del forno
- monitoraggio delle valvole e delle bobine
- verifica cicli di lavoro
- verifica avanzamento commesse
- rilevazione anomalie e gli allarmi
- segnalazione repentina degli allarmi
- verifica trend
- verifica cicli e commesse concluse con indicazione ricetta utilizzata, data e ora di avvio, data e ora di fine

Nello specifico il PLC registra inoltre le ore di lavoro totali del forno ed il numero totale di cicli del forno. L'unità di controllo consente di impostare le "ricette" di trattamento, di salvarle ed avviare i cicli di produzione. Consente inoltre di monitorare costantemente lo stato del forno, le valvole, le bobine, i cicli di lavoro; permette di rilevare le anomalie e gli allarmi, segnalandoli repentinamente.

Il PLC si interfaccia con l'operatore mediante display a colori a bordo macchina che ne consente un utilizzo semplice ed efficiente. Il PLC risulta connesso alla rete ethernet aziendale e si interfaccia con il gestionale di produzione. Risulta altresì accessibile in remoto per manutenzione ed assistenza, oltre che per monitoraggio continuo.

Elenco Indirizzi IP

Il forno risulta identificato dal seguente indirizzo IP: 192. 168.1.120.

Di seguito si rimettono le schermate di collegamento al "forno di cottura TECFLAM MOD. 28" tramite portale di gestione del processo.

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Dashboard del gestionale di processo:

441 551 671 (FISSO+IP - 63.43.29.184 | 192.168.1.99) - 3.6.7 | iperius Remote - iperius-v2.com@8275 - (00:01:19)

iperius Remote

09/06/2022 10:21

AUTOMAZIONE E RIPARAZIONE MOTORI ELETTRICI

REM

FORNO ESSICCAZIONE FORNO DISTRUZIONE GRAFICO F. ESSICCAZIONE GRAFICO F. DISTRUZIONE ARCHIVIO F. ESSICCAZIONE ARCHIVIO F. DISTRUZIONE ALLARMI MENU

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Visualizzazione sinottica dati del forno parametri, ricetta, commessa di lavoro



The screenshot shows a control interface for a 'FORNO ESSICCAZIONE' (Drying Oven). The interface includes a status bar at the top with the date and time '09/06/2022 10:22'. Below this, there are several rows of data:

- ALLARME PRESENTE**: Indicated by a green dot.
- FORNO PRONTO**: Indicated by a green dot.
- TEMPERATURA ATTUALE**: 27
- SETPOINT TEMPERATURA**: 180
- START PROGRAMMA**: Indicated by a red dot.
- RICETTA**: 2 (selected from a dropdown menu labeled 'PROGRAMMA_2').
- COMMessa**: 2022 0155 (shown in two input fields).

At the bottom of the interface, there is a navigation bar with buttons for 'FORNO ESSICCAZIONE', 'FORNO DISTRUZIONE', 'GRAFICO F. ESSICCAZIONE', 'GRAFICO F. DISTRUZIONE', 'ARCHIVIO F. ESSICCAZIONE', 'ARCHIVIO F. DISTRUZIONE', 'ALLARMI', and 'MENU'. A 'CHECK' button is also visible next to the recipe selection.

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Impostazione programma ricetta per commessa (il tasto CHECK consente il controllo della correttezza del programma rispetto alla commessa ed eventualmente ferma il lavoro).



The screenshot shows a control interface for a 'FORNO ESSICCAZIONE' (Drying Oven). The interface includes a status bar at the top with the date and time '09/06/2022 10:22'. Below this, there are several parameters and their values:

- ALLARME PRESENTE**: Indicated by a green dot.
- FORNO PRONTO**: Indicated by a green dot.
- TEMPERATURA ATTUALE**: 27
- SETPOINT TEMPERATURA**: 180
- START PROGRAMMA**: Indicated by a red dot.
- RICETTA**: 2
- COMMESSA**: 2022_0155

There is a dropdown menu for selecting a program, currently showing 'PROGRAMMA 2'. A 'CHECK' button is located to the right of the dropdown. At the bottom of the interface, there is a menu bar with buttons for 'FORNO ESSICCAZIONE', 'FORNO DISTRUZIONE', 'GRAFICO F. ESSICCAZIONE', 'GRAFICO F. DISTRUZIONE', 'ARCHIVIO F. ESSICCAZIONE', 'ARCHIVIO F. DISTRUZIONE', 'ALLARMI', and 'MENU'.

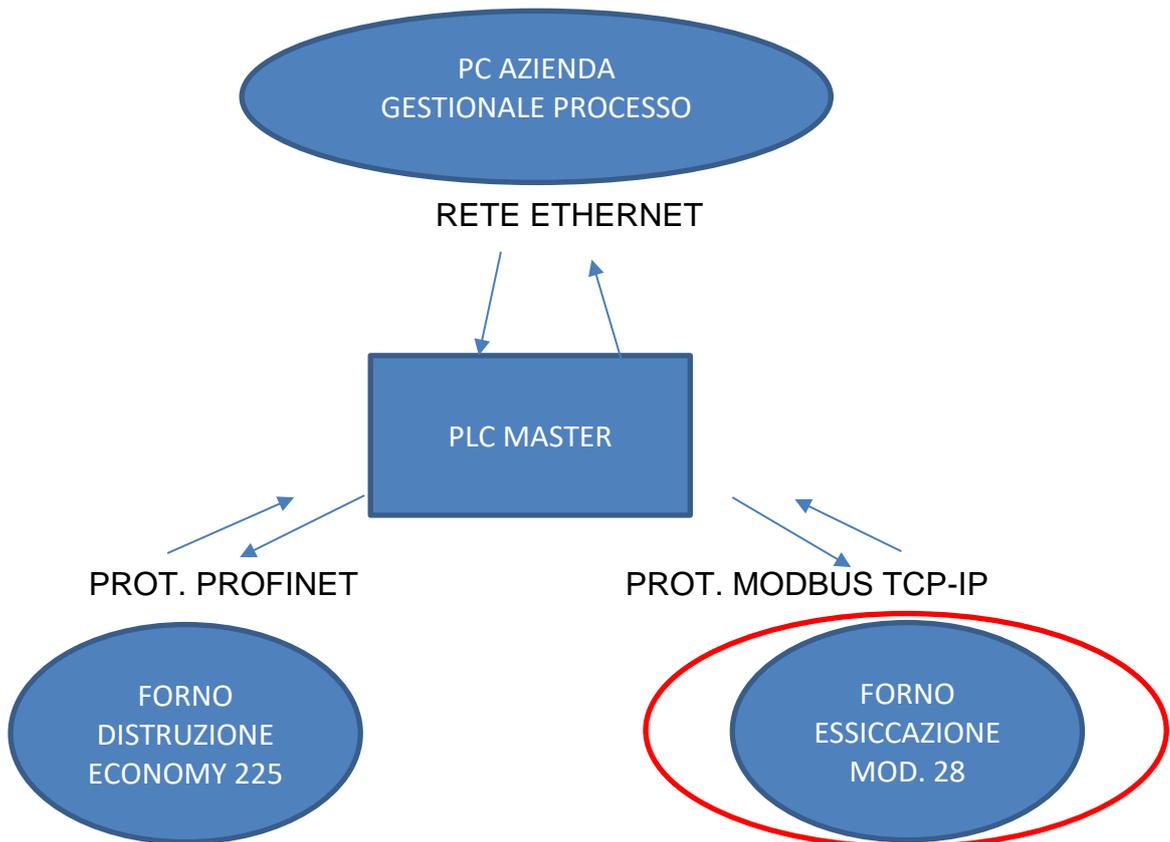
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Di seguito una schematizzazione dell'interconnessione



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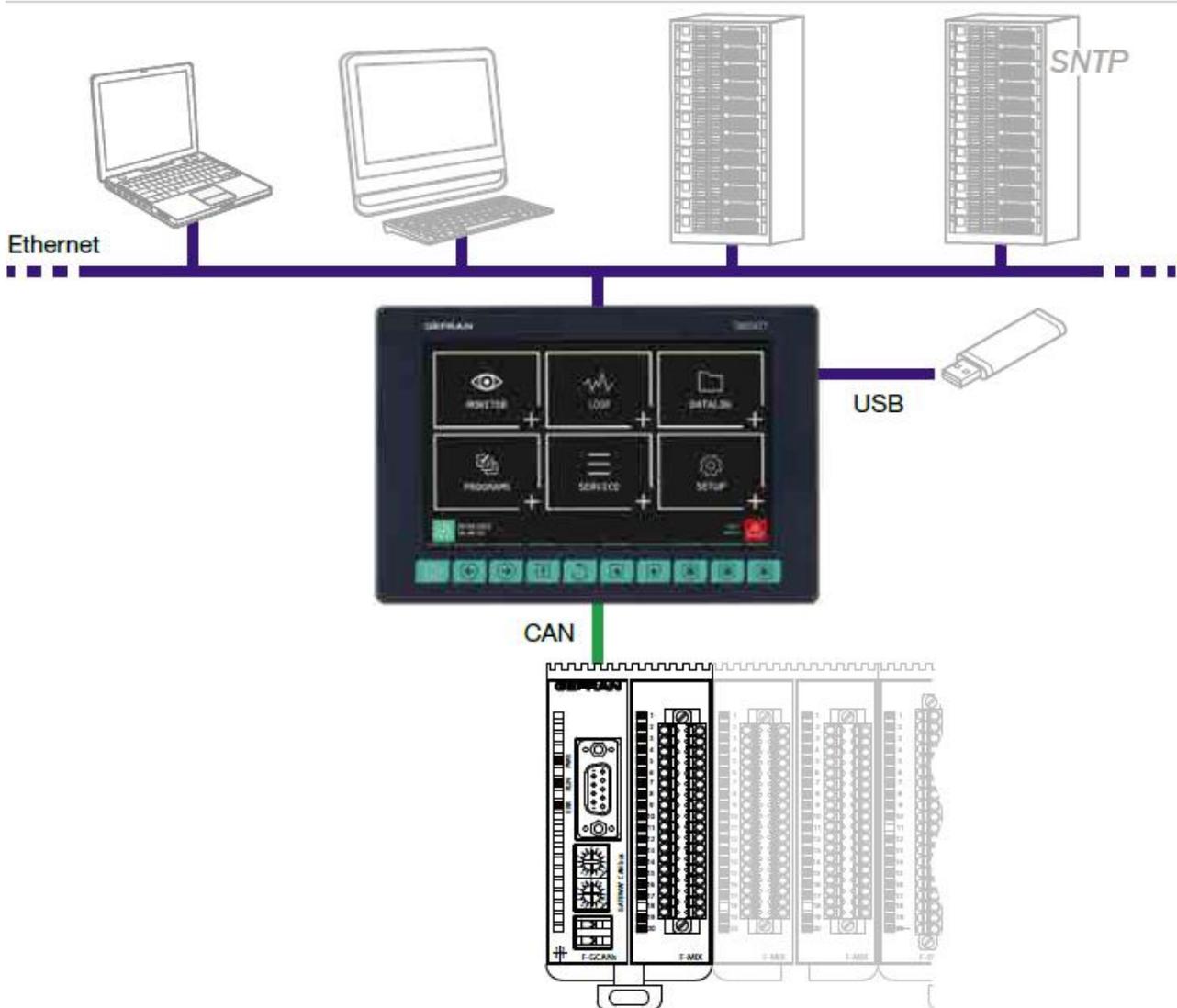
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Di seguito nella seguente checklist sono indicate le caratteristiche di interconnessione:

N°	Descrizione	
1.a	Scambia informazioni con sistemi interni (sistema gestionale, sistemi di pianificazione, sistemi di progettazione. ecc.) oppure	<input checked="" type="checkbox"/>
1.b	Scambia informazioni con sistemi esterni (clienti, fornitori, partner nella progettazione e sviluppo, altri siti di produzione, ecc.)	<input checked="" type="checkbox"/>
2	Lo scambio di informazioni non richiede l'intervento dell'operatore, se non a livello di selezione, supervisione e controllo delle operazioni	<input checked="" type="checkbox"/>
3.a	Lo scambio di informazioni è bidirezionale (cd. "interconnessione forte")	<input checked="" type="checkbox"/>
3.b	Lo scambio di informazioni è unidirezionale (vd.Circolare MiSE del 1 agosto 2018, n.295485 -cd. "interconnessione debole")	<input type="checkbox"/>
4	Lo scambio di informazioni avviene per mezzo di un collegamento basato su specifiche documentate	<input checked="" type="checkbox"/>
5	Lo scambio di Informazioni avviene per mezzo di un collegamento basato su specifiche disponibili pubblicamente	<input checked="" type="checkbox"/>
6	Lo scambio di informazioni avviene per mezzo di un collegamento basato su specifiche internazionalmente riconosciute o (TCP-IP, HTIP, MOTI, ecc.)	<input checked="" type="checkbox"/>
7.a	Lo scambio di Informazioni avviene per mezzo di protocolli riconducibili a standard "de jure"	<input checked="" type="checkbox"/>
7.b	Lo scambio di informazioni avviene per mezzo di protocolli riconducibili a standard "de facto" o "market-driven" per uno o specifico comparto industriale	<input type="checkbox"/>
8	È identificato univocamente, mediante utilizzo di standard di indirizzamento riconosciuti internazionalmente (Indirizzo IP, Mac o Address, IMEI, ecc.)	<input checked="" type="checkbox"/>

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9.a	La modalità di scambio dati avviene attraverso tecnologie wired	<input checked="" type="checkbox"/>
9.b	La modalità di scambio dati avviene attraverso tecnologie wireless	<input type="checkbox"/>
10	Il requisito di interconnessione si realizza attraverso la guida automatica o semiautomatica delle cd. "macchine mobili" (vd. circolare MiSE 23 maggio 2018, n. 177355)	<input type="checkbox"/>
11	La modalità di scambio informativo avviene tramite dispositivi quali gateway, blackbox, router o simili	<input checked="" type="checkbox"/>
12	Sono presenti control room, o comunque funzioni centralizzate di monitoraggio e/o controllo, per la verifica in tempo reale dei parametri operativi	<input checked="" type="checkbox"/>
13	Sono presenti sensori, eventualmente "embedded", con rilevazione singola o multipla dei parametri operativi	<input checked="" type="checkbox"/>
14	Sono presenti sensori "evoluti" per warning e alert, che possono anche proporre la gestione di eventi (per esempio sensori che prevedono in modo intelligente possibili errori e/o malfunzionamenti in base al raffronto tra parametro storico e parametro attuale)	<input checked="" type="checkbox"/>

Il bene soddisfa il requisito obbligatorio RO2.

- c) Integrazione automatizzata con il sistema logistico della fabbrica e/o altre macchine
 Integrazione automatizzata con il sistema logistico della fabbrica o con la rete di fornitura e/o con altre macchine del ciclo produttivo

L'infrastruttura informatica realizzata rende possibile la comunicazione bidirezionale tra azienda e FORNO DI ESSICCAZIONE TECFLAM MOD. 28, dando la possibilità di integrare i dati provenienti dal macchinario e derivanti dal processo con i sistemi aziendali. Tale integrazione avviene in modalità completamente automatica e riguarda la comunicazione mediante protocollo ModBus TCP-IP tra PLC Siemens del forno e PLC master aziendale che, ricevendo i dati di produzione, li elabora in formato SQL e li rende visibili all'interno del gestionale di processo opportunamente predisposto.

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Tali dati vengono poi archiviati nel server aziendale, con possibilità di lettura anche storicizzata ed associata ad ogni singola commessa. Nel dettaglio i dati riguardano:

- monitoraggio costante dello stato del forno
- monitoraggio delle valvole e delle bobine
- verifica cicli di lavoro
- verifica avanzamento commesse
- rilevazione anomalie e allarmi
- segnalazione repentina degli allarmi
- verifica trend
- verifica cicli e commesse concluse con indicazione ricetta utilizzata, data e ora di avvio, data e ora di fine

Nello specifico il PLC registra inoltre le ore di lavoro totali del forno ed il numero totale di cicli del forno. L'unità di controllo consente di impostare le "ricette" di trattamento, di salvarle ed avviare i cicli di produzione. Consente inoltre di monitorare costantemente lo stato del forno, le valvole, le bobine, i cicli di lavoro; permette di rilevare le anomalie e gli allarmi, segnalandoli repentinamente.

Il PLC si interfaccia con l'operatore mediante display a colori a bordo macchina che ne consente un utilizzo semplice ed efficiente. Il PLC risulta connesso alla rete ethernet aziendale e si interfaccia con il gestionale di produzione. Risulta altresì accessibile in remoto per manutenzione ed assistenza, oltre che per monitoraggio continuo.

Di seguito le schermate attestanti l'integrazione automatizzata mediante gestionale di processo:

Report grafici di produzione:

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Grafici forno con verifica costante di andamento e dati di produzione



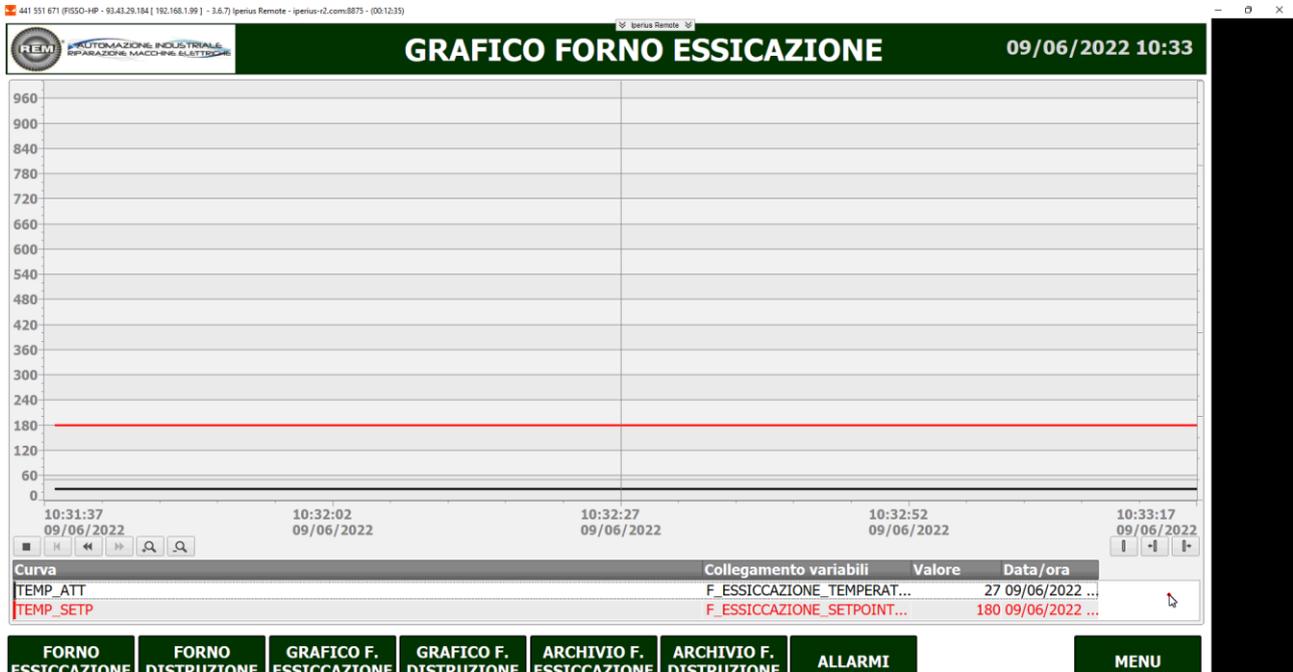
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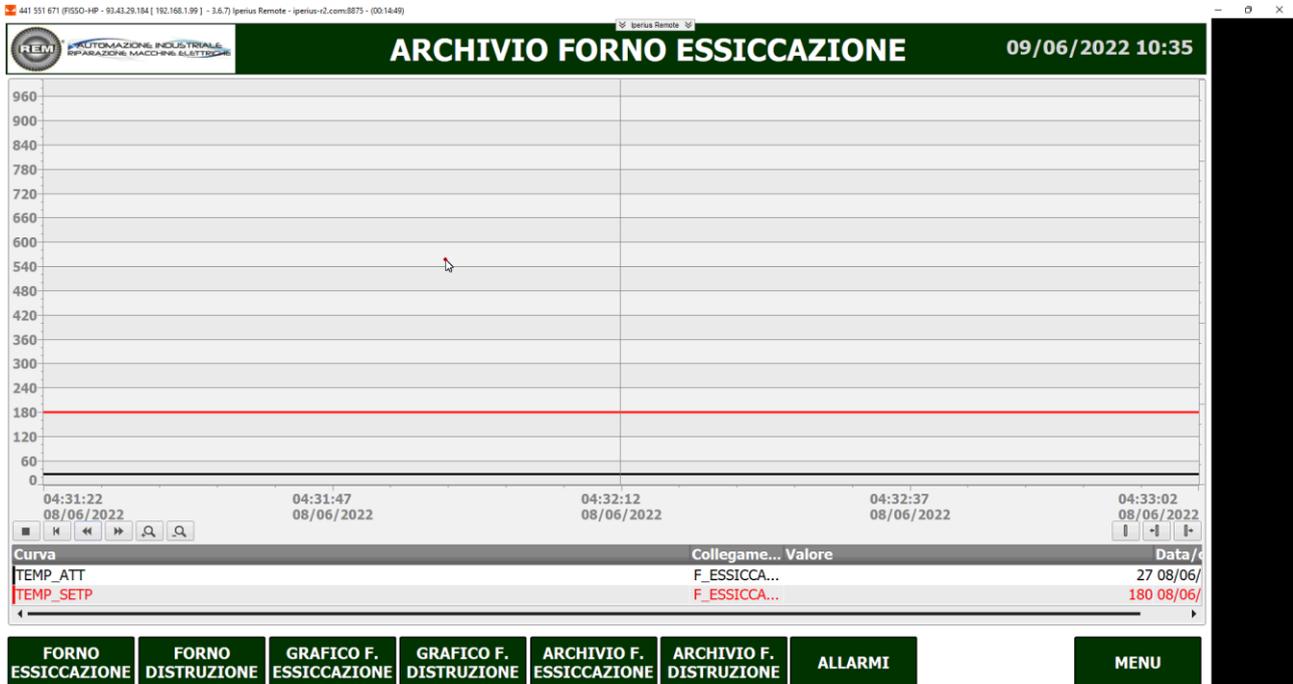
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Archiviazione dati storici



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Visualizzazione allarmi

441 551 671 (RISO-HP - 63.43.29.184 [192.168.1.99] - 3.6.7) Iperius Remote - iperius-v2.com:8275 - (00.16.06)

ipertec Remote

ALLARMI 09/06/2022 10:37

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4	10:...	09/0...	EU	ALLARME FORNO DISTRUZIONE RICETTA INCONGRUENTE	0
2	08:...	09/0...	E	ALLARME FORNO DISTRUZIONE - CONTROLLARE PROCESSO	0

FORNO ESSICCAZIONE FORNO DISTRUZIONE GRAFICO F. ESSICCAZIONE GRAFICO F. DISTRUZIONE ARCHIVIO F. ESSICCAZIONE ARCHIVIO F. DISTRUZIONE ALLARMI MENU

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Archiviazione sql su server azienda - forno essiccazione

The screenshot shows a Microsoft SQL Server Enterprise Manager interface. The 'Query Results' window displays the following data:

Nr	F_ESSECCAZIONE_ALLARME_PRESENT	F_ESSECCAZIONE_FORNO_PRONTO	F_ESSECCAZIONE_TEMPERATURA_ATT	F_ESSECCAZIONE_SETPONTO_TEMPER	F_ESSECCAZIONE_START_PROGRAMMA	F_ESSECCAZIONE_STOP_PROGRAMMA	F_ESSECCAZIONE_RICETTA
899	0	1	27	100	0	0	0
900	0	1	27	100	0	0	0
901	0	1	27	100	0	0	0
902	0	1	27	100	0	0	0
903	0	1	27	100	0	0	0
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905	0	1	27	100	0	0	0
906	0	1	27	100	0	0	0
907	0	1	27	100	0	0	0
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913	0	1	27	100	0	0	0
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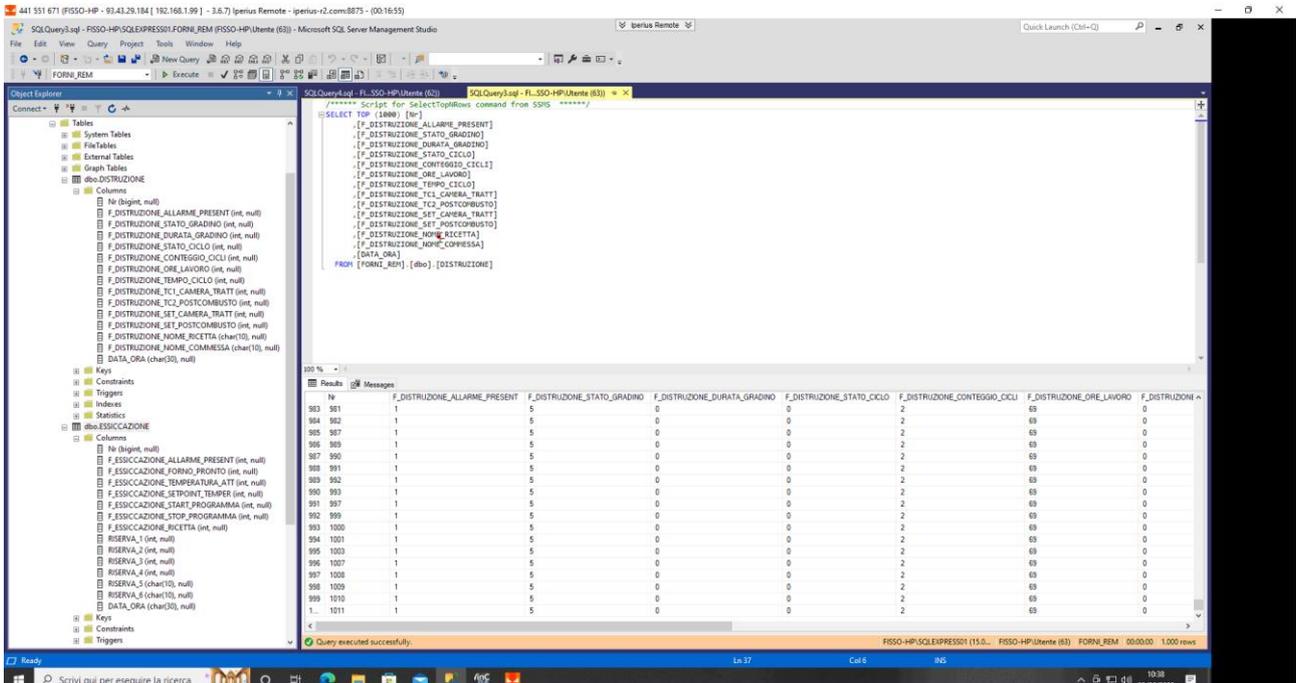
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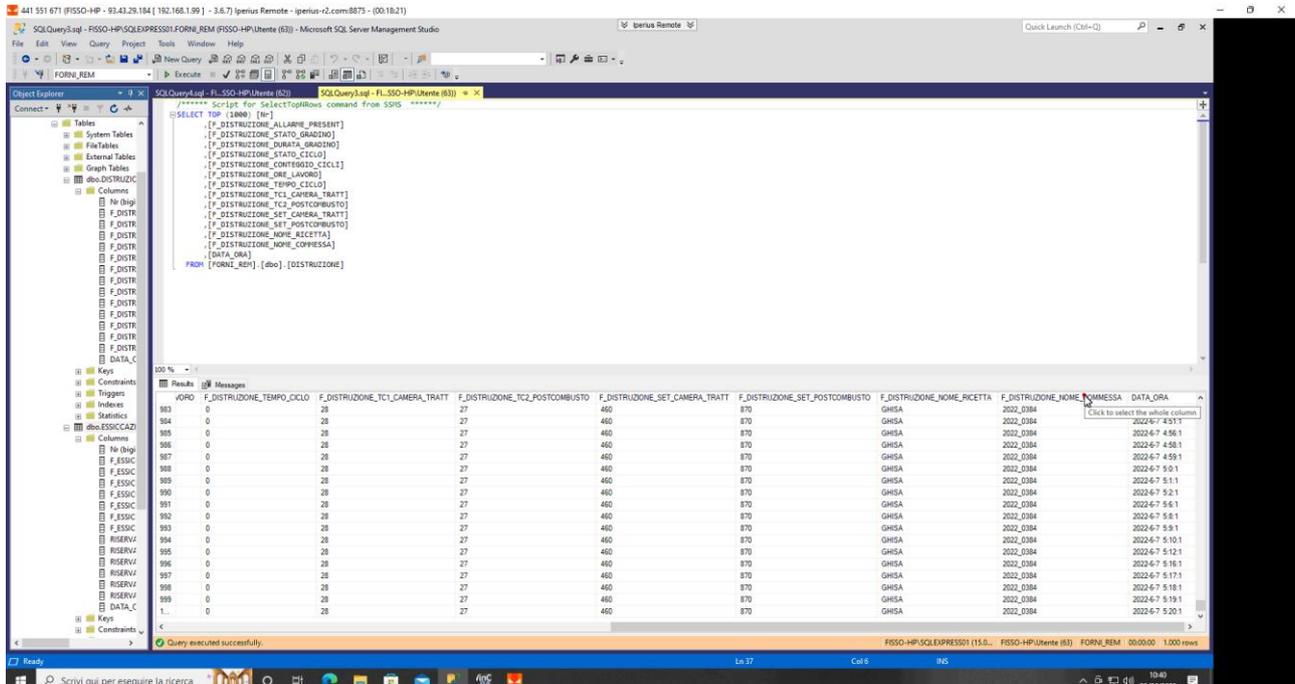
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Data: 24.06.2022
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Riferimento commessa in essere sul server aziendale

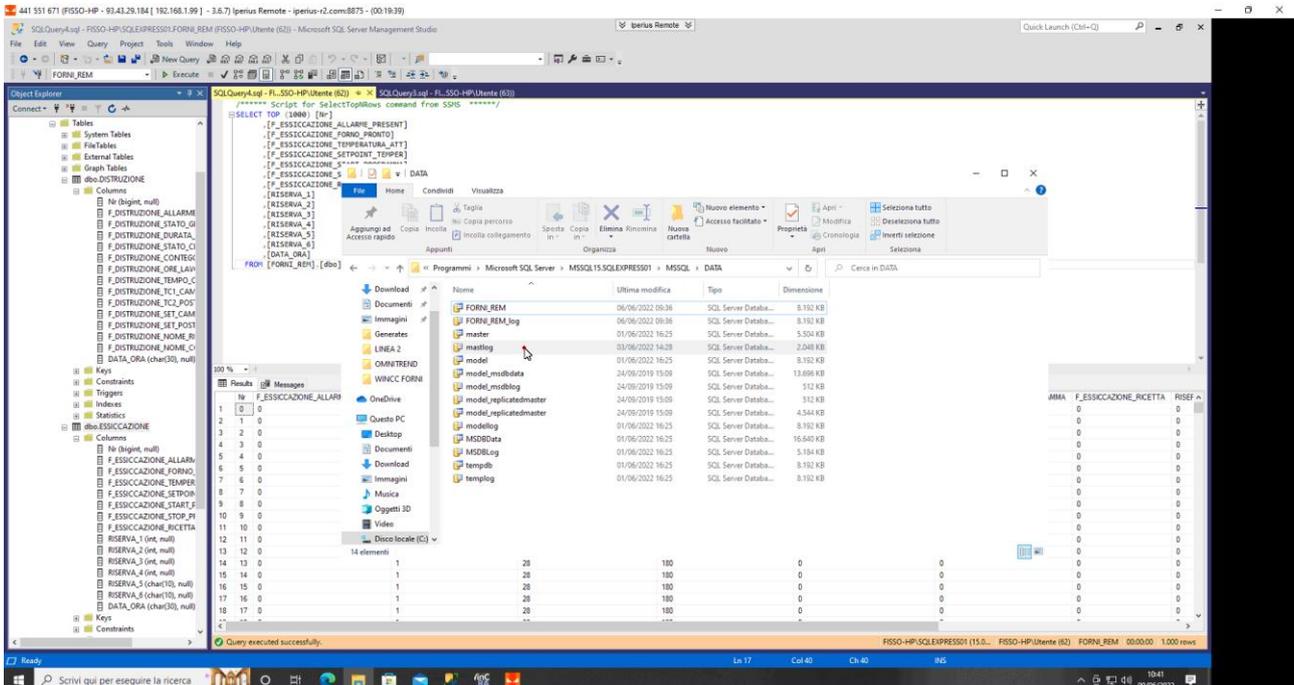


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Il bene soddisfa il requisito obbligatorio RO3.

d) Interfaccia uomo macchina semplice ed intuitiva

Il forno di TECFLAM MOD. 28 risulta dotato di HMI a bordo macchina destinato all'utilizzo ed al controllo della stessa. Trattasi di interfaccia operatore con Display Touch Screen a colori 7" in grado di monitorare le attività e di visualizzare i cicli di lavoro in relazione alle commesse.

Il pannello risulta semplice ed intuitivo e rende possibile:

- l'utilizzo in sicurezza in ogni situazione ambientale e con indosso i DPI;
- la lettura senza errori in qualsiasi situazione ambientale del reparto produttivo;

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- la memorizzazione di dati;
- la ricerca di dati;
- presentazione dei dati in schermate successive strutturate per tipo di attività;
- funzionalità di "help";
- Presenza di icone rappresentative dello stato della macchina;
- Presenza di icone rappresentative della schermata;
- Evidenza degli allarmi emergenti e funzioni di diagnostica.

Di seguito la foto dell'interfaccia HMI e le schermate con evidenza delle icone e delle funzionalità:



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Di seguito una foto esemplificativa del display acceso:



Il bene soddisfa il requisito obbligatorio RO4.

e) Rispondenza ai più recenti parametri di sicurezza, salute ed igiene sul lavoro

La macchina è marcata CE ai sensi delle direttive di prodotto applicabili ed è accompagnata da:

- Dichiarazione CE di conformità;
- Manuale di istruzioni in italiano.

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Il bene soddisfa il requisito obbligatorio RO5.

f) Sistemi di telemanutenzione e/o telediagnosi e/o controllo in remoto

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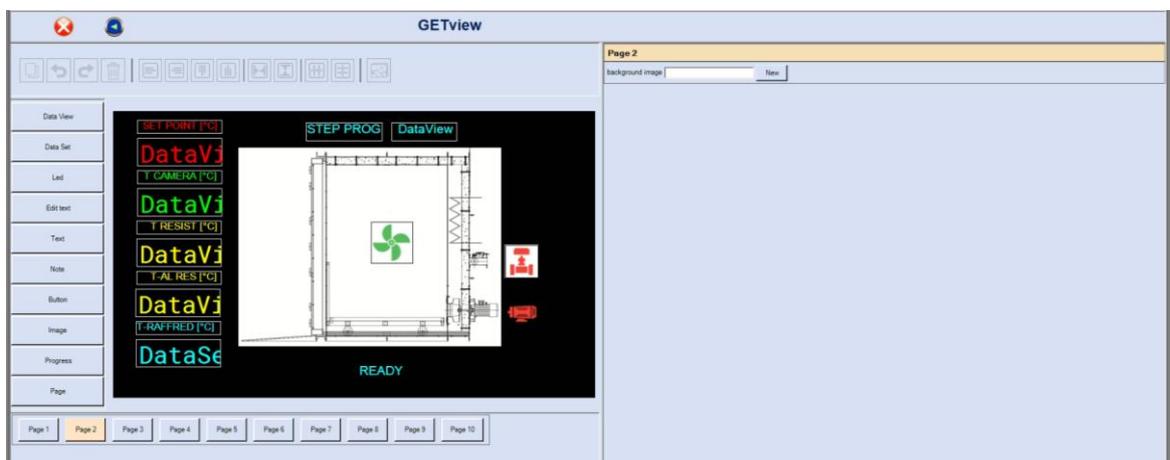
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Il forno TECFLAM MOD. 28 è dotato di sistemi di sensori e allarmi che consentono il controllo costante in termini di mantenimento in efficienza e sicurezza. Il PLC dell'apparecchio risulta dotato di interfaccia ALLARMI in grado di registrare automaticamente tutte le anomalie di sistema verificate dai sensori e dai dispositivi di controllo. Mediante accesso remoto al PLC del forno i tecnici incaricati alla manutenzione possono verificarne costantemente la funzionalità e le eventuali anomalie e criticità, risolvendole mediante l'utilizzo del SW embedded del PLC.

Allo stesso modo è possibile procedere ad un controllo real time, sia dall'HMI a bordo macchina che da remoto mediante collegamento al PLC di:

- monitoraggio costante dello stato del forno;
- monitoraggio delle valvole e delle bobine;
- verifica cicli di lavoro;
- verifica avanzamento commesse;
- rilevazione anomalie e gli allarmi;
- segnalazione repentina degli allarmi.

Tramite tale possibilità, oltre alla verifica delle anomalie e delle criticità, è possibile controllare in remoto le impostazioni, le ricette ed i parametri, intervenendo eventualmente in caso di necessità.



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ALLARMI

Variables											
Name	Value	Address	Comma	Unit	Type	Written	Used	Description	ReadOnly		
PID_01_SELF_C...		238	0		Func						*
PID_02_SELF_C...		239	0		Func						*
PID_03_SELF_C...		240	0		Func						*
PID_04_SELF_C...		241	0		Func						*
LED_F1		254	0		Digital_OUT						
LED_F2		255	0		Digital_OUT						
LED_F3		256	0		Digital_OUT						
PID_01_AL_TH...		7	1		Ret_Func_Register						*
PID_01_AL_TH...		8	1		Ret_Func_Register						*
PID_01_AL_TH...		9	1		Ret_Func_Register						*
PID_01_AL_TH...		10	1		Ret_Func_Register						*
PID_02_AL_TH...		11	1		Ret_Func_Register						*
PID_02_AL_TH...		12	1		Ret_Func_Register						*
PID_02_AL_TH...		13	1		Ret_Func_Register						*
PID_02_AL_TH...		14	1		Ret_Func_Register						*
PID_03_AL_TH...		15	1		Ret_Func_Register						*
PID_03_AL_TH...		16	1		Ret_Func_Register						*
PID_03_AL_TH...		17	1		Ret_Func_Register						*
PID_03_AL_TH...		18	1		Ret_Func_Register						*
PID_04_AL_TH...		19	1		Ret_Func_Register						*
PID_04_AL_TH...		20	1		Ret_Func_Register						*
PID_04_AL_TH...		21	1		Ret_Func_Register						*
PID_04_AL_TH...		22	1		Ret_Func_Register						*
PID_01_EN		71	0		Ret_Func_Register						*
PID_02_EN		72	0		Ret_Func_Register						*
PID_03_EN		73	0		Ret_Func_Register						*
PID_04_EN		74	0		Ret_Func_Register						*
DO_01_TON		88	0		Ret_Func_Register						*
DO_02_TON		89	0		Ret_Func_Register						*

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File View Parameters Target Service Help

Variables

ID	Active	Name	Description	noAck	Level
1	<input type="checkbox"/>	AL1		<input type="checkbox"/>	3
2	<input type="checkbox"/>	AL2		<input type="checkbox"/>	3
3	<input type="checkbox"/>	AL3		<input type="checkbox"/>	3
4	<input type="checkbox"/>	AL4		<input type="checkbox"/>	3
5	<input type="checkbox"/>	AL5		<input type="checkbox"/>	3
6	<input type="checkbox"/>	AL6		<input type="checkbox"/>	3
7	<input type="checkbox"/>	AL7		<input type="checkbox"/>	3
8	<input type="checkbox"/>	AL8		<input type="checkbox"/>	3
9	<input type="checkbox"/>	AL9		<input type="checkbox"/>	3
10	<input type="checkbox"/>	AL10		<input type="checkbox"/>	3
11	<input type="checkbox"/>	AL11		<input type="checkbox"/>	3
12	<input type="checkbox"/>	AL12		<input type="checkbox"/>	3
13	<input type="checkbox"/>	AL13		<input type="checkbox"/>	3
14	<input type="checkbox"/>	AL14		<input type="checkbox"/>	3
15	<input type="checkbox"/>	AL15		<input type="checkbox"/>	3
16	<input type="checkbox"/>	AL16		<input type="checkbox"/>	3
17	<input type="checkbox"/>	AL17		<input type="checkbox"/>	3
18	<input type="checkbox"/>	AL18		<input type="checkbox"/>	3
19	<input type="checkbox"/>	AL19		<input type="checkbox"/>	3
20	<input type="checkbox"/>	AL20		<input type="checkbox"/>	3
21	<input type="checkbox"/>	AL21		<input type="checkbox"/>	3
22	<input type="checkbox"/>	AL22		<input type="checkbox"/>	3
23	<input type="checkbox"/>	AL23		<input type="checkbox"/>	3
24	<input type="checkbox"/>	AL24		<input type="checkbox"/>	3
25	<input type="checkbox"/>	AL25		<input type="checkbox"/>	3
26	<input type="checkbox"/>	AL26		<input type="checkbox"/>	3
27	<input type="checkbox"/>	AL27		<input type="checkbox"/>	3
28	<input type="checkbox"/>	AL28		<input type="checkbox"/>	3
29	<input type="checkbox"/>	AL29		<input type="checkbox"/>	3

Targets connected

File View Parameters Target Service Help

Menu	IP	Name	Type	Value	Default value	Min	Max	Unit	Description	Note	Short Description	Address
	4051	LO5_1	Float	0.3	---	-32767	32767		Minimum scale limit			4050
	4052	LO5_2	Float	0	---	-32767	32767		Minimum scale limit			4051
	4053	LO5_3	Float	0	---	-32767	32767		Minimum scale limit			4052
	4054	LO5_4	Float	0	---	-32767	32767		Minimum scale limit			4053
	4055	LO5_5	Float	0	---	-32767	32767		Minimum scale limit			4054
	4056	LO5_6	Float	0	---	-32767	32767		Minimum scale limit			4055
	4057	LO5_7	Float	0	---	-32767	32767		Minimum scale limit			4056
	4058	LO5_8	Float	0	---	-32767	32767		Minimum scale limit			4057
	4059	LO5_9	Float	0	---	-32767	32767		Minimum scale limit			4058
	4060	LO5_10	Float	0	---	-32767	32767		Minimum scale limit			4059
	4061	LO5_11	Float	0	---	-32767	32767		Minimum scale limit			4060
	4062	LO5_12	Float	0	---	-32767	32767		Minimum scale limit			4061
	4063	LO5_13	Float	0	---	-32767	32767		Minimum scale limit			4062
	4064	LO5_14	Float	0	---	-32767	32767		Minimum scale limit			4063
	4065	LO5_15	Float	0	---	-32767	32767		Minimum scale limit			4064
	4066	LO5_16	Float	0	---	-32767	32767		Minimum scale limit			4065
	4101	HL_1	Float	0.1	---	0.0	0.1		User maximum limit			4100
	4102	HL_2	Float	1000	---	0	1000		User maximum limit			4101
	4103	HL_3	Float	1000	---	0	1000		User maximum limit			4102
	4104	HL_4	Float	1000	---	0	1000		User maximum limit			4103
	4105	HL_5	Float	1000	---	0	1000		User maximum limit			4104
	4106	HL_6	Float	1000	---	0	1000		User maximum limit			4105
	4107	HL_7	Float	1000	---	0	1000		User maximum limit			4106
	4108	HL_8	Float	1000	---	0	1000		User maximum limit			4107
	4109	HL_9	Float	1000	---	0	1000		User maximum limit			4108
	4110	HL_10	Float	1000	---	0	1000		User maximum limit			4109
	4111	HL_11	Float	1000	---	0	1000		User maximum limit			4110
	4112	HL_12	Float	1000	---	0	1000		User maximum limit			4111
	4113	HL_13	Float	1000	---	0	1000		User maximum limit			4112
	4114	HL_14	Float	1000	---	0	1000		User maximum limit			4113
	4115	HL_15	Float	1000	---	0	1000		User maximum limit			4114
	4116	HL_16	Float	1000	---	0	1000		User maximum limit			4115
	4151	LO1_1	Float	0.0	---	0.0	0.1		User minimum limit			4150
	4152	LO1_2	Float	0	---	0	1000		User minimum limit			4151
	4153	LO1_3	Float	0	---	0	1000		User minimum limit			4152
	4154	LO1_4	Float	0	---	0	1000		User minimum limit			4153
	4155	LO1_5	Float	0	---	0	1000		User minimum limit			4154
	4156	LO1_6	Float	0	---	0	1000		User minimum limit			4155
	4157	LO1_7	Float	0	---	0	1000		User minimum limit			4156
	4158	LO1_8	Float	0	---	0	1000		User minimum limit			4157
	4159	LO1_9	Float	0	---	0	1000		User minimum limit			4158
	4160	LO1_10	Float	0	---	0	1000		User minimum limit			4159
	4161	LO1_11	Float	0	---	0	1000		User minimum limit			4160
	4162	LO1_12	Float	0	---	0	1000		User minimum limit			4161

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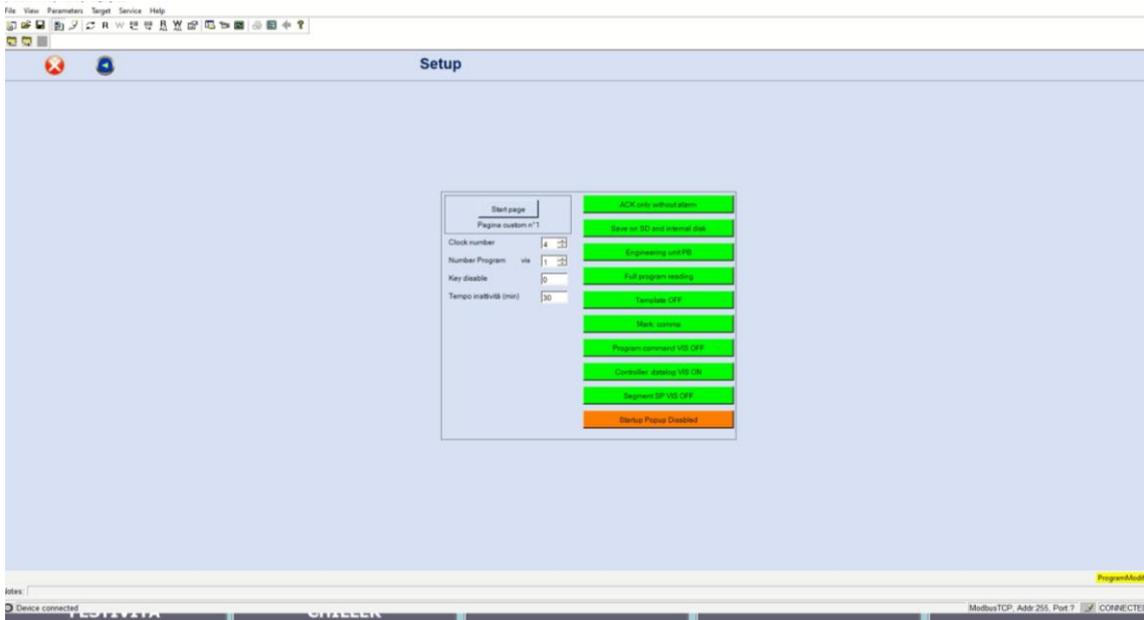
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Menu	IPA	Name	Type	Value	Default value	Min	Max	Unit	Description	Note	Short Description	Address
	4051	LO5_1	Float	0.0	---	-32767	32767		Minimum scale limit			4050
	4052	LO5_2	Float	0	---	-32767	32767		Minimum scale limit			4051
	4053	LO5_3	Float	0	---	-32767	32767		Minimum scale limit			4052
	4054	LO5_4	Float	0	---	-32767	32767		Minimum scale limit			4053
	4055	LO5_5	Float	0	---	-32767	32767		Minimum scale limit			4054
	4056	LO5_6	Float	0	---	-32767	32767		Minimum scale limit			4055
	4057	LO5_7	Float	0	---	-32767	32767		Minimum scale limit			4056
	4058	LO5_8	Float	0	---	-32767	32767		Minimum scale limit			4057
	4059	LO5_9	Float	0	---	-32767	32767		Minimum scale limit			4058
	4060	LO5_10	Float	0	---	-32767	32767		Minimum scale limit			4059
	4061	LO5_11	Float	0	---	-32767	32767		Minimum scale limit			4060
	4062	LO5_12	Float	0	---	-32767	32767		Minimum scale limit			4061
	4063	LO5_13	Float	0	---	-32767	32767		Minimum scale limit			4062
	4064	LO5_14	Float	0	---	-32767	32767		Minimum scale limit			4063
	4065	LO5_15	Float	0	---	-32767	32767		Minimum scale limit			4064
	4066	LO5_16	Float	0	---	-32767	32767		Minimum scale limit			4065
	4101	HL_1	Float	0.1	---	0.0	0.1		User maximum limit			4100
	4102	HL_2	Float	1000	---	0	1000		User maximum limit			4101
	4103	HL_3	Float	1000	---	0	1000		User maximum limit			4102
	4104	HL_4	Float	1000	---	0	1000		User maximum limit			4103
	4105	HL_5	Float	1000	---	0	1000		User maximum limit			4104
	4106	HL_6	Float	1000	---	0	1000		User maximum limit			4105
	4107	HL_7	Float	1000	---	0	1000		User maximum limit			4106
	4108	HL_8	Float	1000	---	0	1000		User maximum limit			4107
	4109	HL_9	Float	1000	---	0	1000		User maximum limit			4108
	4110	HL_10	Float	1000	---	0	1000		User maximum limit			4109
	4111	HL_11	Float	1000	---	0	1000		User maximum limit			4110
	4112	HL_12	Float	1000	---	0	1000		User maximum limit			4111
	4113	HL_13	Float	1000	---	0	1000		User maximum limit			4112
	4114	HL_14	Float	1000	---	0	1000		User maximum limit			4113
	4115	HL_15	Float	1000	---	0	1000		User maximum limit			4114
	4116	HL_16	Float	1000	---	0	1000		User maximum limit			4115
	4150	LOL_1	Float	0.0	---	0.0	0.1		User maximum limit			4150
	4152	LOL_2	Float	0	---	0	1000		User minimum limit			4151
	4153	LOL_3	Float	0	---	0	1000		User minimum limit			4152
	4154	LOL_4	Float	0	---	0	1000		User minimum limit			4153
	4155	LOL_5	Float	0	---	0	1000		User minimum limit			4154
	4156	LOL_6	Float	0	---	0	1000		User minimum limit			4155
	4157	LOL_7	Float	0	---	0	1000		User minimum limit			4156
	4158	LOL_8	Float	0	---	0	1000		User minimum limit			4157
	4159	LOL_9	Float	0	---	0	1000		User minimum limit			4158
	4160	LOL_10	Float	0	---	0	1000		User minimum limit			4159
	4161	LOL_11	Float	0	---	0	1000		User minimum limit			4160
	4162	LOL_12	Float	0	---	0	1000		User minimum limit			4161



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- Il bene soddisfa il requisito ulteriore RU1**
 Il bene NON soddisfa il requisito ulteriore RU1

g) Monitoraggio in continuo

Monitoraggio continuo delle condizioni di lavoro e dei parametri di processo mediante opportuni set di sensori e adattività alle derive di processo

Il forno Tecfam Mod. 28 risulta caratterizzato da un sistema che consente un monitoraggio continuo delle attività, volto sia a garantire il corretto svolgimento dei processi sia la sicurezza e l'efficienza del macchinario. I sensori presenti sul macchinario garantiscono il costante controllo dei sistemi e dei parametri di utilizzo con possibilità di interfacciamento e lettura immediata degli stessi sia a livello di HMI locale che da remoto con collegamento da VPN direttamente sul PLC, sia attraverso il gestionale di processo di cui l'azienda si è dotata.

Il forno è equipaggiato con due termo-resistenze di tipo PT100 L 250mm

Vista la loro importanza ai fini della regolazione e del buon funzionamento dell'impianto, vanno controllate con frequenza almeno settimanale e comunque non superiore ai 10 cicli.

I parametri oggetto di controllo e monitoraggio costante sono rappresentati da:

- temperatura di prelavaggio
- tempo prelavaggio
- temperatura fase di trattamento 1
- tempo fase trattamento 1
- temperatura fase di trattamento 2
- tempo fase trattamento 2
- potenza e consumo
- monitoraggio costante dello stato del forno
- monitoraggio dei sensori
- verifica cicli di lavoro
- verifica avanzamento commesse
- rilevazione anomalie e gli allarmi
- segnalazione repentina degli allarmi
- verifica trend

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- verifica cicli e commesse concluse con indicazione ricetta utilizzata, data e ora di avvio, data e ora di fine

Allo stesso modo il gestionale di processo a cui il sistema risulta interconnesso e con il quale comunica in termini di integrazione automatizzata risulta dotato di un sistema di check che consente una verifica del processo prima e durante lo svolgimento delle attività. La verifica riguarda la coerenza e la correttezza tra la ricetta impostata e la commessa di lavoro trasmessa al forno, con sistema che blocca in automatico l'accensione dei bruciatori in caso di anomalia rilevata.

Di seguito le schermate:

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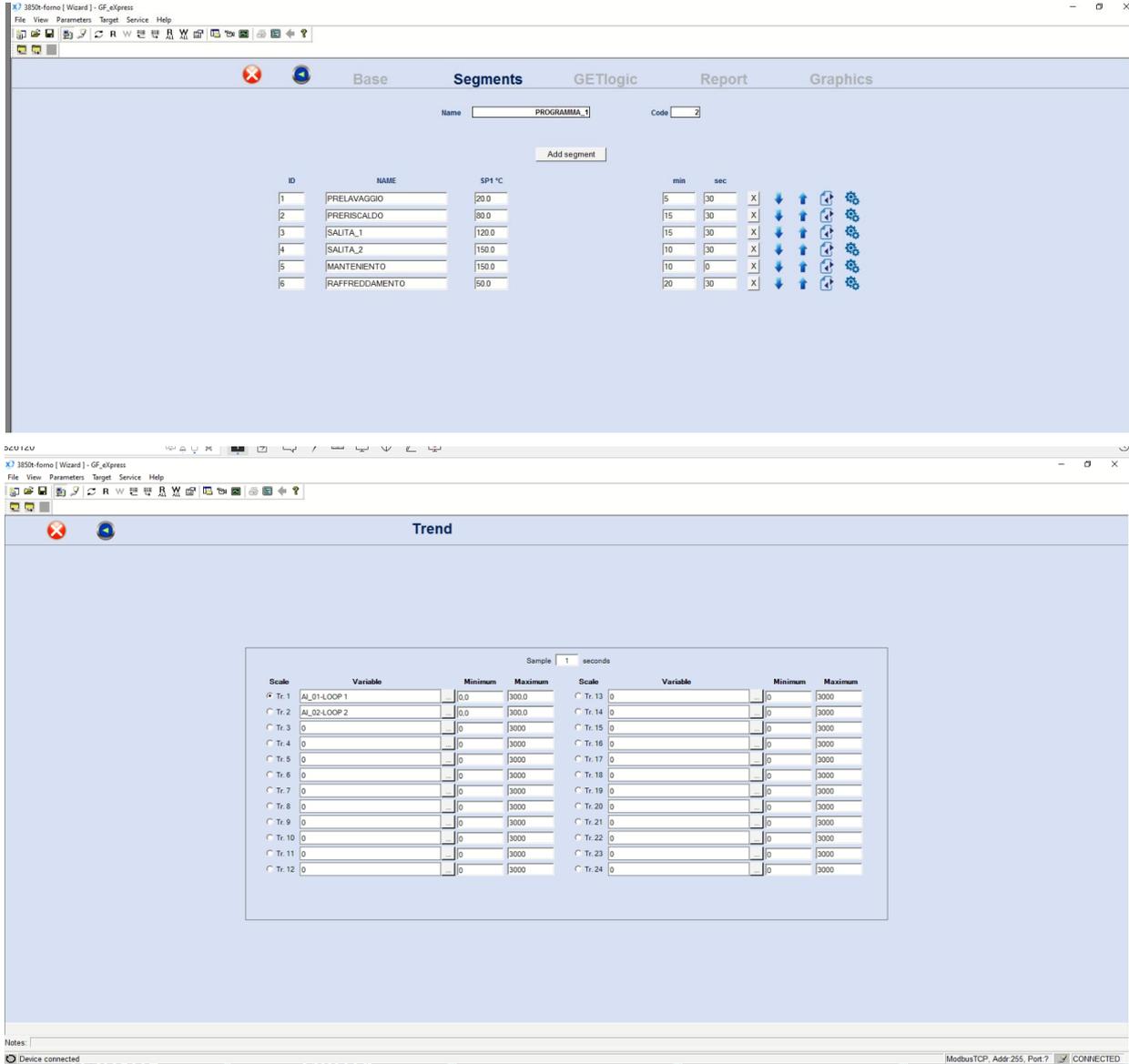
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Visualizzazione dello stato momentaneo (monitoraggio trend e parametri impostati) delle attività del forno tramite **collegamento remoto al PLC del macchinario**:



The screenshot displays two windows from the '3850h-forno' software. The top window, titled 'Segments', shows a table of process segments with columns for ID, NAME, SP1 °C, min, and sec. The bottom window, titled 'Trend', shows a table of variables with columns for Scale, Variable, Minimum, Maximum, and Scale, along with a 'Sample' rate of 1 second.

ID	NAME	SP1 °C	min	sec
1	PRELAVAGGIO	20.0	5	30
2	PRERISCALDO	80.0	15	30
3	SALITA_1	120.0	15	30
4	SALITA_2	150.0	10	30
5	MANTENIMENTO	150.0	10	0
6	RAFFREDDAMENTO	50.0	20	30

Scale	Variable	Minimum	Maximum	Scale	Variable	Minimum	Maximum
Tr. 1	AL_01-LOOP 1	0.0	300.0	Tr. 13		0	3000
Tr. 2	AL_02-LOOP 2	0.0	300.0	Tr. 14		0	3000
Tr. 3	0	0	3000	Tr. 15		0	3000
Tr. 4	0	0	3000	Tr. 16		0	3000
Tr. 5	0	0	3000	Tr. 17		0	3000
Tr. 6	0	0	3000	Tr. 18		0	3000
Tr. 7	0	0	3000	Tr. 19		0	3000
Tr. 8	0	0	3000	Tr. 20		0	3000
Tr. 9	0	0	3000	Tr. 21		0	3000
Tr. 10	0	0	3000	Tr. 22		0	3000
Tr. 11	0	0	3000	Tr. 23		0	3000
Tr. 12	0	0	3000	Tr. 24		0	3000

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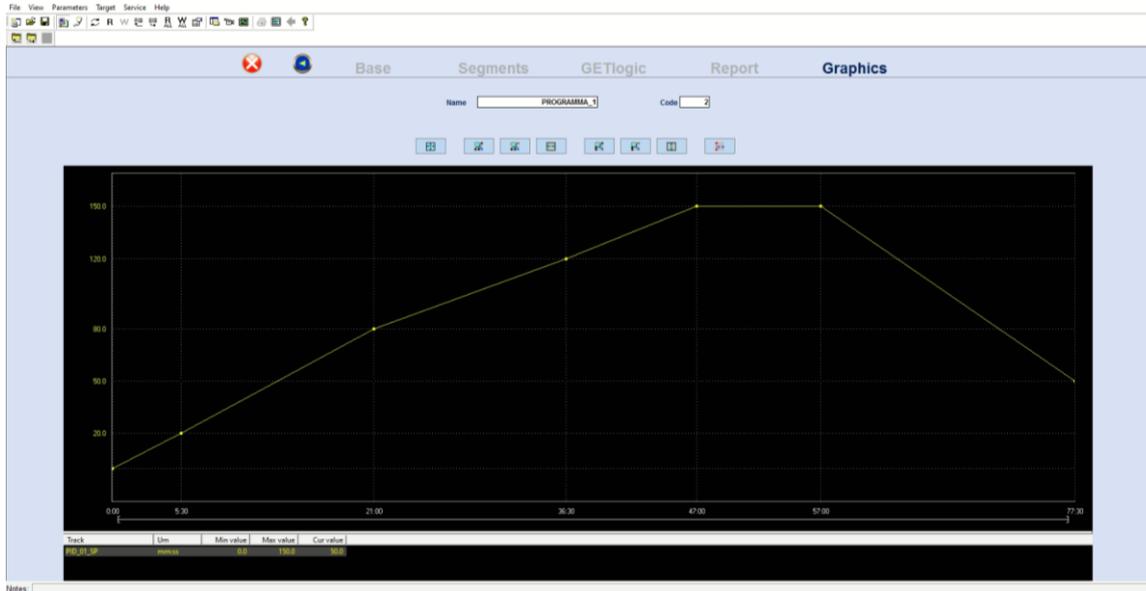
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Visualizzazione continua (trend grafico) del lavoro



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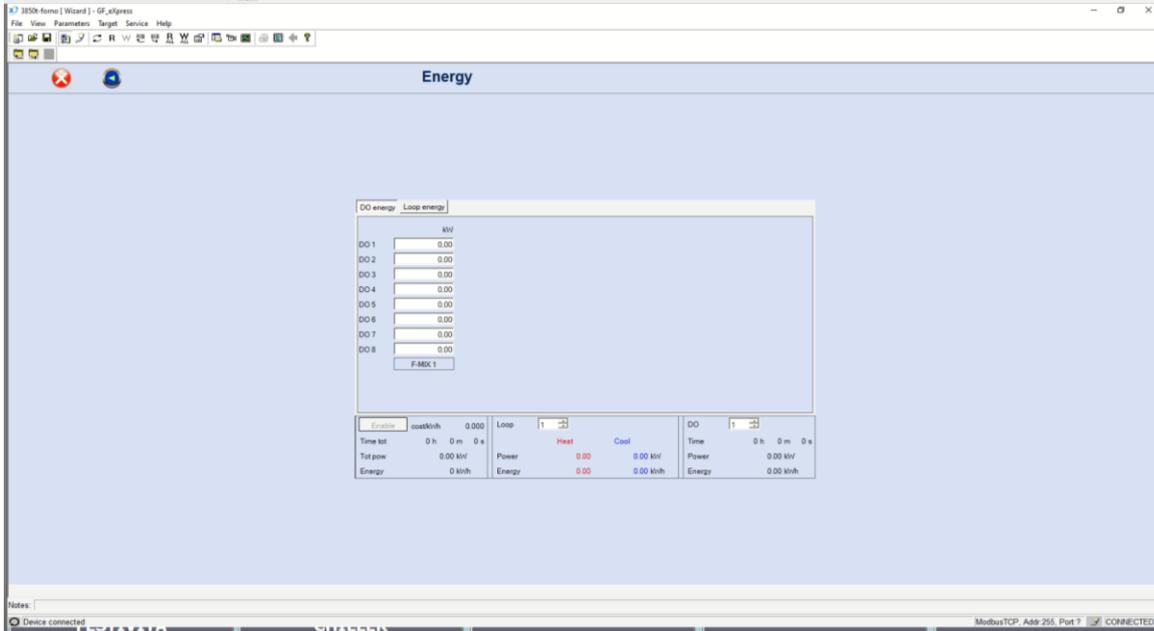
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Visualizzazione potenza e consumo momentanei tramite collegamento al PLC del forno:



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Visualizzazione allarmi momentanei tramite collegamento al PLC del forno:

The image shows two screenshots of a software interface. The top screenshot displays a 'Variables' table with columns for Name, Value, Address, Comment, Unit, Type, Written, Used, Description, and ReadOnly. The bottom screenshot shows a 'Variables' table with columns for ID, Active, Name, Description, read/write, and Level, listing various alarm points (AL1 to AL29).

Name	Value	Address	Comment	Unit	Type	Written	Used	Description	ReadOnly
PIO_01_SEL_F_C	238	0			Func				
PIO_02_SEL_F_C	239	0			Func				
PIO_03_SEL_F_C	240	0			Func				
PIO_04_SEL_F_C	241	0			Func				
LED_F1	254	0			Digital_OUT				
LED_F2	255	0			Digital_OUT				
LED_F3	256	0			Digital_OUT				
PIO_01_AL_TH	7	1			Rel_Func_Register				
PIO_01_AL_TH	8	1			Rel_Func_Register				
PIO_01_AL_TH	9	1			Rel_Func_Register				
PIO_01_AL_TH	10	1			Rel_Func_Register				
PIO_02_AL_TH	11	1			Rel_Func_Register				
PIO_02_AL_TH	12	1			Rel_Func_Register				
PIO_02_AL_TH	13	1			Rel_Func_Register				
PIO_02_AL_TH	14	1			Rel_Func_Register				
PIO_03_AL_TH	15	1			Rel_Func_Register				
PIO_03_AL_TH	16	1			Rel_Func_Register				
PIO_03_AL_TH	17	1			Rel_Func_Register				
PIO_03_AL_TH	18	1			Rel_Func_Register				
PIO_04_AL_TH	19	1			Rel_Func_Register				
PIO_04_AL_TH	20	1			Rel_Func_Register				
PIO_04_AL_TH	21	1			Rel_Func_Register				
PIO_04_AL_TH	22	1			Rel_Func_Register				
PIO_01_EN	71	0			Rel_Func_Register				
PIO_02_EN	72	0			Rel_Func_Register				
PIO_03_EN	73	0			Rel_Func_Register				
PIO_04_EN	74	0			Rel_Func_Register				
DO_01_TON	88	0			Rel_Func_Register				
DO_02_TON	89	0			Rel_Func_Register				

ID	Active	Name	Description	read/write	Level
1		AL1			3
2		AL2			3
3		AL3			3
4		AL4			3
5		AL5			3
6		AL6			3
7		AL7			3
8		AL8			3
9		AL9			3
10		AL10			3
11		AL11			3
12		AL12			3
13		AL13			3
14		AL14			3
15		AL15			3
16		AL16			3
17		AL17			3
18		AL18			3
19		AL19			3
20		AL20			3
21		AL21			3
22		AL22			3
23		AL23			3
24		AL24			3
25		AL25			3
26		AL26			3
27		AL27			3
28		AL28			3
29		AL29			3

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Visualizzazione schermate di monitoraggio continuo da gestionale di processo:

Grafici forno



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Allarmi

441 551 671 (FISO+P - 63.43.29.184 | 192.168.1.99 | - 3.6.7) Iperius Remote - iperius-v2.com:8275 - (00:16:06)

ipertus Remote

ALLARMI 09/06/2022 10:37

N°.	Te...	Data	S...	Testo	Confer...
3	10:...	09/0...	EU	ALLARME FORNO DISTRUZIONE COMMESSA INCONGRUENTE	0
4	10:...	09/0...	EU	ALLARME FORNO DISTRUZIONE RICETTA INCONGRUENTE	0
2	08:...	09/0...	E	ALLARME FORNO DISTRUZIONE - CONTROLLARE PROCESSO	0

FORNO ESSICCAZIONE
 FORNO DISTRUZIONE
 GRAFICO F. ESSICCAZIONE
 GRAFICO F. DISTRUZIONE
 ARCHIVIO F. ESSICCAZIONE
 ARCHIVIO F. DISTRUZIONE
 ALLARMI
 MENU

- Il bene soddisfa il requisito ulteriore RU2
- Il bene NON soddisfa il requisito ulteriore RU2

h) Caratteristiche di integrazione

Caratteristiche di integrazione tra macchina fisica e/o impianto con la modellizzazione e/o la simulazione del proprio comportamento nello svolgimento del processo (sistema cyberfisico)

Non applicabile

- Il bene soddisfa il requisito ulteriore RU3
- Il bene NON soddisfa il requisito ulteriore RU3

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6 Control Check

6.1 Check List 1 – Beni Allegato A strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori ed azionamenti (Gruppo I)

Voce	Descrizione	
1.01	Macchine utensili per asportazione. In tale contesto si fa riferimento a tutte le macchine atte alla trasformazione di pezzi, indipendentemente dal materiale lavorato (metallo, marmo, polimeri, legno ceramica, ecc) . Ne sono un esempio torni a CN, centri di lavoro, centri di rettifica, ecc	○
1.02	Macchine utensili operanti con laser e altri processi a flusso di energia (ad esempio plasma, waterjet, fascio di elettroni), elettroerosione, processi elettrochimici. Sono comprese, per esempio, macchine per la lavorazione ad ultrasuono (USM), a getto abrasivo (AJM), waterjet (WJM), chimiche (CHM), elettrochimiche (ECM), elettroerosione (EDM), taglio laser (LBM), con fascio di elettroni o di ioni (EBM), plasma (PAM), ecc	○
1.03	Macchine e impianti per la realizzazione di prodotti mediante la trasformazione dei metalli e delle materie prime. In questo caso si intendono macchine e impianti impiegati nell'industria manifatturiera discreta, nell'industria di processo e in quella di trasformazione che devono essere dotati di proprietà di riconfigurabilità, di flessibilità. La voce in elenco è applicabile indipendentemente dal prodotto (o semilavorato) realizzato o trasformato o trattato e dal relativo ciclo tecnologico e indipendentemente dal tipo di realizzazione o trasformazione o trattamento (meccanico, chimico, fisico, ecc) indotto sul prodotto o semilavorato. Per impianto o porzione di impianto si intende un insieme di macchine connesse fisicamente fra loro anche se ogni macchina o attrezzatura funziona in maniera indipendente. L'impianto gode del beneficio fiscale anche nel caso in cui i singoli componenti provengano da fornitori diversi	⊙
1.04	Macchine utensili per la deformazione plastica dei metalli e altri materiali. Si intendono tutte quelle macchine che eseguono deformazione plastica operanti sia a freddo che a caldo. Ne sono un esempio presse, punzonatrici a CN, laminatoi, pannellatrici, trafilatrici, ecc	○

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1.05	Macchine utensili per l'assiemeaggio, la giunzione e la saldatura. In questo caso possono essere compresi anche linee , celle e sistemi di assemblaggio	<input type="radio"/>
1.06	Macchine per il confezionamento e l'imballaggio. Queste possono includere ad esempio macchine adibite al packaging e all'imbottigliamento	<input type="radio"/>
1.07	Macchine utensili di de-produzione e riconfezionamento per recuperare metalli e funzioni da scarti industriali e prodotti di ritorno a fine vita (ad es. macchine per il disassemblaggio, la separazione, la frantumazione, il recupero chimico). Sono inclusi i dispositivi che, in un'ottica di economia circolare, sono finalizzati all'riutilizzo diretto, alla riparazione, al remanufacturing e al riciclo / riutilizzo delle materie prime. Sono da ritenersi escluse le macchine finalizzate allo smantellamento in discarica e finalizzate al recupero energetico	<input type="radio"/>
1.08	Robot, robot collaborativi e sistemi multi robot	<input type="radio"/>
1.09	Macchine utensili e sistemi per il conferimento o la modifica delle caratteristiche superficiali dei prodotti o la funzionalizzazione delle superfici. Ne sono un esempio lappatrici, rettificatrici, macchine per trattamenti superficiali, termici e/o chimici, macchine per il coating, macchine per la granigliatura, sabbiatura, pallinatura, vibrofinitura, funzionalizzazione mediante plasma stampa su carta e tessuti, funzionalizzazione con plasma, smaltatura, decorazione della ceramica.	<input type="radio"/>
1.10	Macchine per la manifattura additiva utilizzata in ambito industriale. Ne sono un esempio le macchine per laser melting / sintering di polveri metalliche o polimeri, ecc.	<input type="radio"/>
1.11	Macchine anche motrici e operatrici (sono comprese per esempio macchine per l'agricoltura 4.0, quali tutte le trattrici e le macchine agricole portate, trainate e semoventi – che consentono la lavorazione di precisione in campo grazie all'utilizzo di elettronica, sensori e gestione computerizzata delle logiche di controllo; sono inoltre inclusi i dispositivi e macchine di supporto quali , ad esempio, sistemi di sensori in campo , stazioni meteo e droni), strumenti e dispositivi per il carico e lo scarico, la movimentazione , la pesatura e la cernita automatica dei pezzi (ad es. carrelli elevatori, sollevatori, carriponte, gru mobili, gru a portale), dispositivi per il sollevamento e la manipolazione automatizzati (es manipolatori industriali, sistemi di pallettizzazione e dispositivi pick and place), AGV e sistemi di convogliamento e movimentazione flessibili e/o dotati di riconoscimento pezzi (ad esempio sistemi attivi come	<input type="radio"/>

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	RFID, sistemi passivi come ad esempio QR code, visori e sistemi di visione meccatronici). Si precisa che l'espressione macchine motrici non include i veicoli ai sensi della definizione di cui all'articolo 1 della Direttiva 70/156/CEE.	
1.12	Magazzini automatizzati interconnessi ai sistemi gestionali di fabbrica. Si intendono per esempio magazzini automatici asserviti da trasloelevatori o mini loader e software per la gestione delle missioni in/out, i sistemi di selezione prelievo e deposito automatico controllati da software di gestione e/o controllo delle scorte e dei punti di riordino.	○
1.13	Dispositivi, strumentazione e componentistica intelligente per l'integrazione, la sensorizzazione e/o l'interconnessione e il controllo automatico dei processi utilizzati anche nell'ammodernamento o nel revamping dei sistemi di produzione esistenti. Per dispositivi, strumentazione e componentistica si intendono anche package e componenti di impianto purchè assicurino che la macchina o l'impianto oggetto di ammodernamento rispettino, grazie all'ammodernamento, le caratteristiche obbligatorie e le ulteriori caratteristiche. Inoltre, si specifica che, nei casi di revamping di un impianto consegnato prima del 2017, godono del beneficio fiscale solo i beni in oggetto (i dispositivi, la strumentazione, e la componentistica compresi i package e componenti di impianto) e non l'intero impianto ammodernato.	○

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7 Conclusioni

Per quanto sopra indicato con la presente Analisi Tecnica si attesta che il bene << FORNO DI COTTURA TECFLAM MOD. 28 S/N 21.2486.001>>

- rientra in una delle categorie definite nell'allegato A che identifica i beni strumentali il cui funzionamento è controllato da sistemi computerizzati o gestito tramite opportuni sensori e azionamenti;
- soddisfa le caratteristiche indicate nell'Allegato A della Legge 11.12.2016 n. 232 e s.m.i.

Il bene pertanto soddisfa tutte le caratteristiche tecniche richieste affinché l'azienda utilizzatrice possa fruire dell'agevolazione fiscale prevista dal Nuovo Piano Nazionale Transizione 4.0.

La presente relazione è stata redatta a titolo confidenziale, fermi i diritti di utilizzo del richiedente per i fini previsti dalla legge e dal contratto.

Fine del documento

Luogo e data di emissione: Milano, 24.06.2022

Ispettore (nome, data e firma):

Ing. Carlo Giussani – 24.06.2022

Resp. operativo (nome, data e firma):

Alessia Michelini – 24.06.2022

On behalf of Business Manager

SGS Italia S.p.A.
On behalf of Business Manager
A. Michelini


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