

ifm electronic



Processes in the Steel Industry

www.ifm.com/gb/steel

ifm – close to you!

Modern production lines in steelmaking ensure economic success



The steel industry is among the largest and best-established economic sectors worldwide. It has always been an important driving force of the economy. Its products are indispensable for other industries such as automotive and construction.

Quality, reliability and economic efficiency in the production of steel products can only be ensured by means of automated manufacturing facilities.

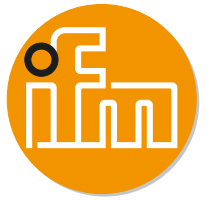
A central objective of ifm is to increase reliability and operational availability of production lines.

In addition to the proven sensor technology, new areas of application such as condition-based maintenance or monitoring of consumables in plants are constantly opened up.

In the future, too, ifm will remain a reliable and innovative partner for the steel industry.

ifm – close to you

ifm electronic





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The company in your vicinity.



State-of-the-art communication.

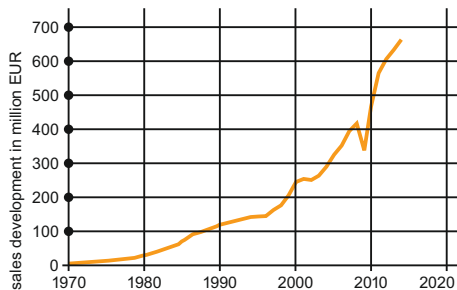
With the right address – www.ifm.com – only a mouse click separates you from the world of automation technology. See the power of our products in interactive representations. Gain an impression with 3-dimensional views of our units. Download CAD drawings for direct integration in your applications. Or order online in ifm's e-shop – fast, convenient and reliable.

We are there for you.

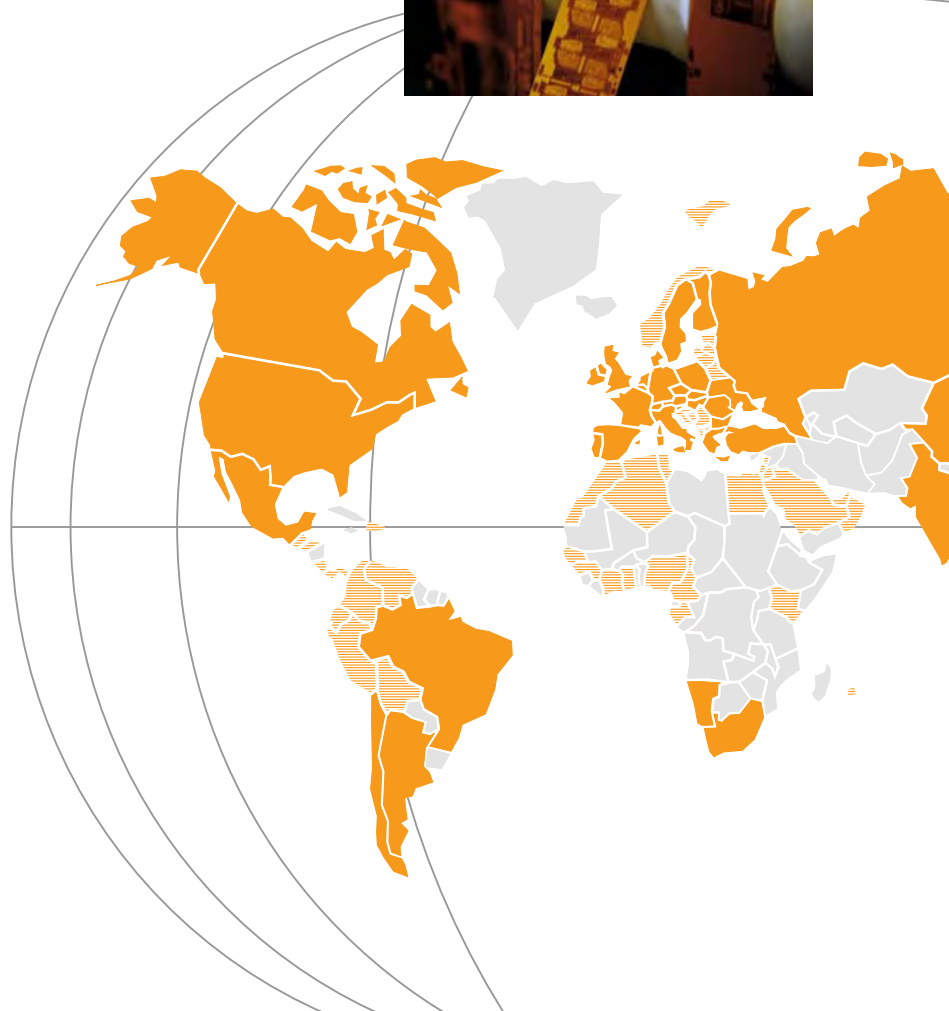
Close contact with our customers is part of our success. Therefore we have consistently developed our sales network right from the start. Today the ifm group of companies is represented in more than 70 countries – close to you! With application advice and service at the heart of our operation. For the introduction of new products and technologies we support you with workshops and seminars in our training centres or in your plant.

Security by success.

Since its foundation in 1969 ifm has constantly grown, now having more than 5500 employees worldwide, and achieved a turnover of more than EUR 720 million in 2015. This success gives you the security of having a reliable partner for the implementation of your automation projects. Comprehensive service and a warranty of 5 years on standard units are just two examples of this reliability.



Turnover development since 1970.



Not only components.

ifm stands for a large range of different sensors and systems for automation. Our range of more than 7,800 articles guarantees flexibility and compatibility. So there is always a reliable solution for your automation projects – from the individual sensor with practical accessories to the complete system.

Availability guaranteed.

Your deadlines matter to us. That is why we are constantly optimising our production processes in order to be able to quickly and flexibly produce large quantities at a constantly high quality – and to continue to shorten delivery times. Your order is dispatched via our centralised logistics centre reliably and on time.

Quality as part of our philosophy.

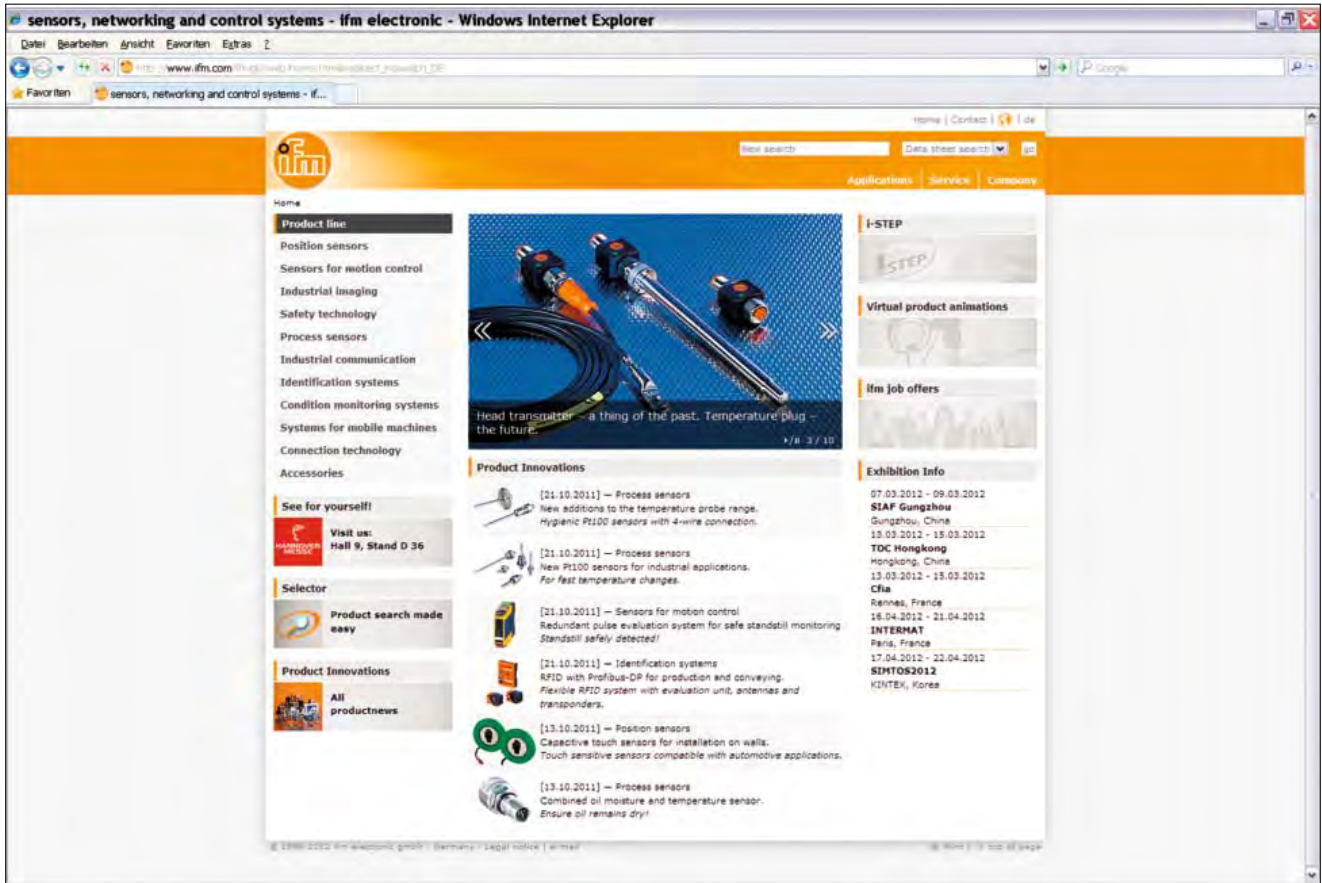
The quality standard of our products is an integral part of our company philosophy. And we guarantee it! So we provide you, the users, with a maximum degree of security: By means of our own production technology, ifm film technology, as well as by means of extensive quality assurance measures such as 100 % final testing. By quality we understand, for example, ecologically conscious production – Made in Germany!



The development of innovative products is one of our core competences. From high-quality standard solutions to products specially tailored to the requirements of the individual industries – from mobile machines to the food industry.

www.ifm.com

Information around the clock and around the globe in 23 languages on the internet.



• Information

- product innovations
- company news
- exhibition info
- locations
- jobs

• Documentation

- data sheets
- operating instructions
- manuals
- approvals
- CAD data

• Communication*

- request for documents
- recall service
- live advice
- newsletter

• Selection

- interactive product selection aids
- configuration tools
- data sheet direct

• Animation

- virtual product animations
- flash movies (video sequences)

• Application

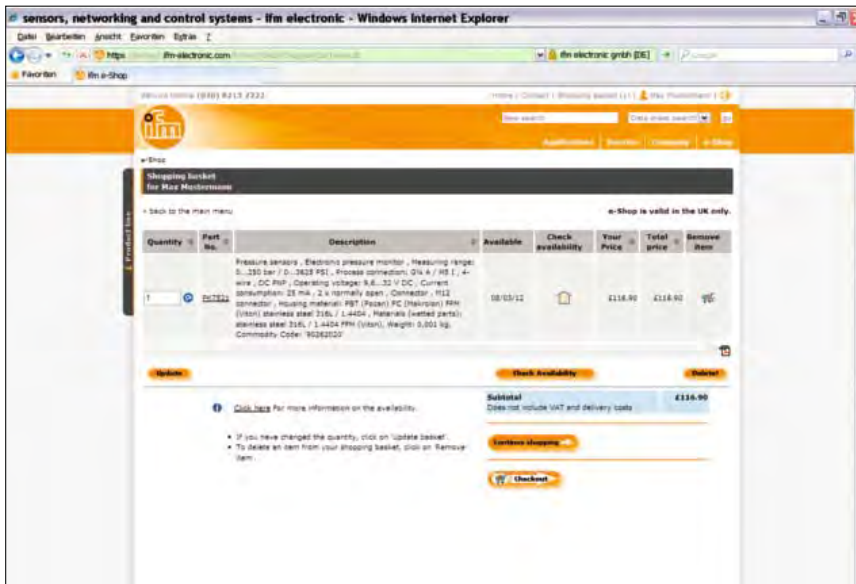
- applications
- product recommendations
- calculation aids

• Transaction*

- e-shop processing
- e-procurement catalogues

*Some offered information is available country-specific

Convenient order processing via the e-shop** on the internet.



Secured authentication

Customer-related price indication

Real time availability check

Personal product favourites

Online parcel tracking

Individual order history

Convenient quick input form

Simple order processing

Management of shipping addresses

Confirmations by e-mail



ifm application database

ifm's automation technology is used to for applications in many different types of plant in almost all industries. Learn how ifm can improve your production.

Application examples can be found on our website at:

www.ifm.com/gb/applications

** Already available in many countries.

3A



3A Sanitary Standards, Inc. (3-A SSI) is an independent, not-for-profit corporation dedicated to advancing hygienic equipment design for the food, beverage, and pharmaceutical industries.

AS-i



Actuator-Sensor Interface. Bus system for the first binary field level.

ATEX



Atmosphère Explosible. ATEX comprises the directives of the European Union in the field of explosion protection. On the one hand there is the 94/9/EC ATEX product directive and on the other hand the 1999/92/EC ATEX operation directive.

CCC



CCC (China Compulsory Certification) is a compulsory Chinese certification for certain products put on the market in China. Which products are concerned is specified in a catalogue created by the Chinese authorities.

cCSAus



Testing of a product by CSA according to the safety standards applicable in Canada and the USA.

CE



Conformité Européenne. By affixing the CE marking to a product, the manufacturer declares that it meets EU safety, health and environmental requirements.

cRUus



Testing of components by UL according to the safety standards applicable in Canada and the USA. Components can be used when the "condition of acceptability" is complied with for the final product.

CSA



Canadian Standards Association. A non-governmental Canadian organisation that sets standards and tests and certifies products for their reliability. By now it is active worldwide.

cULus



Testing of components by UL according to the safety standards applicable in Canada and the USA.

DIBt (WHG)



Deutsches Institut für Bautechnik (Federal Water Act). The Federal Water Act (WHG) is the essential part of the German law relating to water. It contains provisions for the protection and use of surface water and ground water and also regulations about the expansion of waters, water planning and flood protection.

DKD



The Deutscher Kalibrierdienst (DKD) is an association of calibration laboratories of industrial firms, research institutes, technical authorities, inspection and testing institutes. The DKD calibration certificates prove traceability to national standards as required in ISO 9000 and ISO / IEC 17025. They also serve as a metrological basis for the control of measurement and test equipment within the framework of quality management.

E1



Approval by the Kraftfahrt-Bundesamt (German Federal Motor Transport Authority). The E1 type approval by the German Federal Motor Transport Authority certifies that the units comply with the automotive standards. Units with this marking are allowed to be mounted on vehicles without expiry of their operating permit.

EG 1935/2004

The Regulation EC 1935/2004 has been taken into account for process sensors from ifm which are intended for use in contact with food. You can obtain a list of the corresponding products and detailed information on request.

EHEDG



European Hygienic Engineering & Design Group. European supervisory authority for food and drugs. This authority grants approvals for products and materials used in the food and pharmaceutical industries.

FDA



Food and Drug Administration. US-American supervisory authority for food and drugs. This authority grants approvals for products and materials used in the food and pharmaceutical industries.

FM



Factory Mutual Research. A US-based insurance company that specializes in loss prevention services in the property insurance market sector. They provide material research, material testing and certifications in the field of fire and explosion protection.

PROFIBUS



Process Field Bus. Fieldbus system for important data quantities. It is available in several versions such as Profibus FMS, DP or PA. Profibus DP can be used over longer distances, e.g. as fieldbus for AS-i.

TÜV

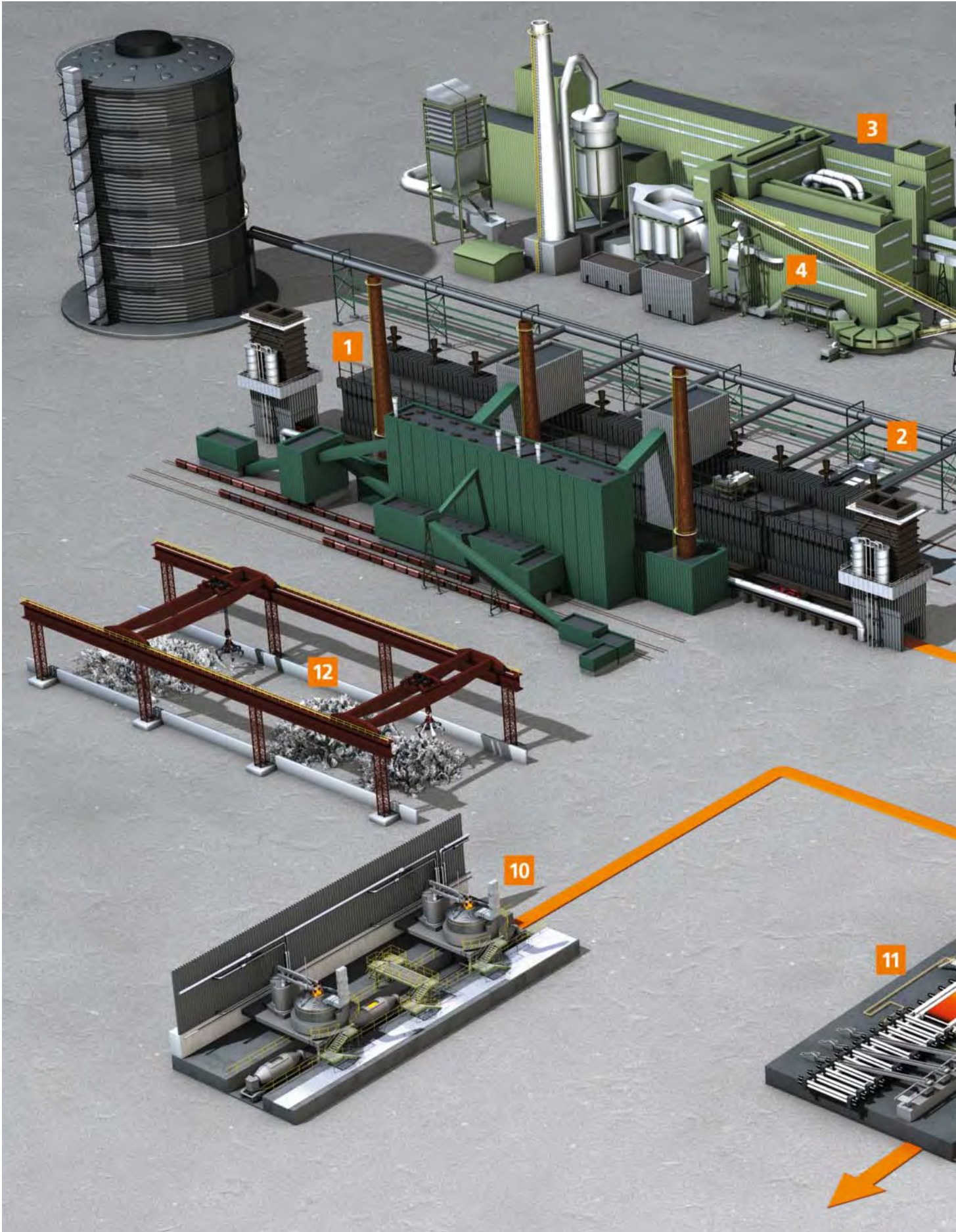


Technischer Überwachungs Verein (technical inspection association). The German TÜV is a private-sector body carrying out technical safety tests that are stipulated by government laws or instructions.






UL



Underwriters Laboratories. An organisation founded in the USA for testing and certifying products and their safety.





Machine	Application	Product group
1 Coke plant		
	Position detection of a furnace door	Cylinder sensors
	Position detection of a filling machine	Inductive sensors
	Monitoring of conveyors	Pulse evaluation systems
2 Hydraulic power pack of a pusher		
	Pressure monitoring in hydraulic power packs	Pressure sensors
	Level monitoring in hydraulic power packs	Level sensors
	Temperature measurement in hydraulic power packs	Temperature sensors
	Vibration monitoring	Vibration monitoring systems
3 Sintering plant		
	Gas supply	Pressure sensors
	Tracking of material	Temperature sensors
	Hatch monitoring at silos	Inductive sensors
	Pressure monitoring at the air inlet	Pressure sensors
4 Conveying systems		
	Decentralised speed monitoring	Pulse evaluation systems
	Safety switches in AS-i Safety at Work	AS-Interface Safety at Work
	Integration of mechanical switches into AS-i systems	AS-Interface Safety at Work
5 Cooling water supply at a blast furnace		
	Pump monitoring	Pressure sensors
	Monitoring of the cooling circuits	Flow sensors / flow meters
	Water pressure monitoring	Pressure sensors
	Monitoring of cooling water	Temperature sensors
6 Converter supply		
	Pressure monitoring in hydraulic power packs	Pressure sensors
	Temperature measurement in hydraulic power packs	Temperature sensors
	Level monitoring in hydraulic power packs	Level sensors
	Vibration monitoring	Vibration monitoring systems

Machine	Application	Product group
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7 Material supply at a converter



Slide monitoring at silos	Cylinder sensors
Hatch monitoring at silos	Inductive sensors
Level monitoring at silos	Capacitive sensors

8 Central compressed air supply



Pressure monitoring at a compressed air reservoir	Pressure sensors
Energy efficiency measurement of the compressed air	Flow sensors / flow meters
Monitoring at an air dryer	Level sensors
Pressure monitoring at the distributor	Pressure sensors

9 Continuous casting plant



Slag detection at a shroud tube manipulator	Vibration monitoring systems
Monitoring of the cooling circuits	Flow sensors / flow meters
Tracking of material	Temperature sensors
Vibration monitoring	Vibration monitoring systems

10 Cooling at an electric arc furnace



Volumetric flow monitoring in cooling circuits	Flow sensors / flow meters
Temperature monitoring in cooling circuits	Temperature sensors
Pressure measurement on pumps	Pressure sensors

11 Flame cutters



Position detection	Inductive sensors
Gas pressure monitoring	Pressure sensors
Gas supply	Inductive sensors
Consumption measurement of technical gases	Flow sensors / flow meters

12 Crane installations



Collision protection	Inductive sensors
Reliable area surveillance	Inductive sensors
End position monitoring	Inductive sensors
Bearing monitoring	Vibration monitoring systems

Modern production plants in steelmaking ensure economic success



Today's steel industry with its modern blast furnaces for pig iron production and the different converter methods can make products with a consistently high quality at low cost.

Because there is a high degree of plant automation the reliability of the components is a critical factor for the economic efficiency of the companies.

Here, sensors play a special role. Whereas in the past they were only used for process control they today provide additional information about the plant condition. Required maintenance and repair can be planned and prepared precisely.

ifm sensors with diagnostic functions are used for condition-based maintenance and contribute to cost reduction. Sensors from ifm help increase the reliability and uptime of the installations.


Hydraulic power pack in coke machines



Monitoring of the system pressure with a multi-colour display

Thanks to the multi-colour display of the electronic pressure sensor the user can quickly and easily see whether the hydraulic power pack generates the required pressure.

Pressure sensors


Type	Process connection	Display	Measuring range [bar]	Poverload max. [bar]	Pbursting min. [bar]	U _b DC [V]	Order no.
	G ¼ female	Display unit	0...25	150	350	18...30	PN7093




Monitoring of power packs

LK and TR series sensors detect the level and the temperature in hydraulic power packs.

LK level sensors

Type	Probe length [mm]	Active zone [mm]	Inactive zone [mm]	U _b [V]	Medium temperature water [°C]	Medium temperature oil [°C]	I _{load} [mA]	Order no.
	472	390	53 / 30	18...30	0...35 (LK1023 + E43101: 0...60)	0...70	200	LK1023

Evaluation units for temperature sensors

Type	Measuring range [°C]	Process connection	Display	U _b [V]	Current consumption [mA]	I _{load} [mA]	Order no.
	-40...300	G ½ male	Display unit	18...32	50	250	TR7432


Oil cooler in a coke machine



Fan monitoring on oil coolers

The oil is cooled to a defined value. The VKV vibration monitor to DIN ISO 10816 detects any damage to the rotating parts in the fan system.

Vibration sensor for bearing monitoring

Type	Description	Order no.
	Vibration monitor · Connection via M12 connector · Vibration monitor to DIN ISO 10816 · Measuring range RMS: 0...25 mm/s · Switching output NC DC PNP and analogue output 4...20 mA · Housing materials: PBT / PC / FPM / stainless steel 316L / 1.4404	VKV021


Degassing dampers of the coke oven batteries



Position detection of a degassing damper

During the coking process when coke is produced from bituminous coal the degassing damper is always in a defined condition. Magnetic sensors are used for damper monitoring.

Magnetic sensors to determine the position on cylinders

Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f [Hz]	I_{load} [mA]	Order no.
	M18 / L = 60	70	High-grade st. steel	10...30	IP 65 / IP 67	5000	200	MGS204


Gas supply in a sintering plant



Gas supply in the sintering process

The sinter material is heated during the sintering process and sucked onto a grate using negative pressure. To ensure a steady feed of the tanks the gas pressure is monitored using electronic pressure sensors.

Pressure sensors for gas monitoring

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G ¼ female	Display unit	-1...10	75	150	18...32	PN2024


Decentralised monitoring of conveyors



Protection of conveyor belts

The safety relay detects via sensors whether the conveyor belt is centred and no e-stop function was triggered.

Evaluation relay for safety technology

Type	U _b [V]	In-puts	Input function	Setting range [puls. / min.]	Setting range [Hz]	Out-puts analogue	Out-puts relays	Out-puts transist.	Order no.
	24 DC	1	PNP	–	0.2 / 0.5 / 1.0 / 2.0	–	2	1	DA1015
	24 DC	1	PNP	–	0.2 / 0.5 / 1.0 / 2.0	–	2	1	DA1025

Safety switches in AS-i Safety at Work



Integration of safety switches into AS-i Safety at Work by means of PCBs

Thanks to safe AS-i PCBs conventional rope switches can be integrated into AS-i Safety networks. Thus, the functionality of the switches combines with the easy installation of AS-i.

AS-i safety PCB

Type	Inputs / outputs	Description	Order no.
	2 safe inputs / 1 unsafe LED output	AS-i safety PCB · Complies with the requirements: IEC 61508: SIL 3	E70155


Integration of mechanical switches into AS-i systems



Integration of belt drift switches into AS-i networks using PCBs

Thanks to AS-i PCBs belt drift switches on conveyor belts can be integrated into AS-i networks. Thus, the functionality of the switches combines with the easy installation of AS-i.

AS-i PCB

Type	Inputs / outputs	Description	Order no.
	4 inputs / 4 outputs	Active AS-i module · AS-i slave with extended addressing mode · Only for operation with AS-i masters with the profile M4 · 12 x 0.2 m · housing: PC potted	AC2750


Pump monitoring at a blast furnace



Pump protection on heavy duty pumps

With regulated heavy duty pumps cavitation may occur if the pump duty is too high. Special pressure sensors detect the cavitation and down-regulate the pump duty.

Pressure sensors for monitoring the pump motor

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	Aseptoflex	Display unit	-1...25	100	350	18...32	PIM093


Monitoring the cooling circuits at a blast furnace



Safe operation in blast furnaces

Blast furnaces have several cooling circuits. In order to ensure a reliable operation of the blast furnaces these cooling circuits are monitored using electronic flow sensors.

Flow sensors for monitoring cooling circuits

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	3...300 / 200...3000	stainless steel 316L / 1.4404	-25...80	30	1...10	19...36	SI5000


Hydraulic power packs in secondary metallurgy




Hydraulic power packs in steelworks

LK and TR series sensors detect the level and the temperature in hydraulic power packs.

LK level sensors

Type	Probe length [mm]	Active zone [mm]	Inactive zone [mm]	U _b [V]	Medium temperature water [°C]	Medium temperature oil [°C]	I _{load} [mA]	Order no.
	472	390	53 / 30	18...30	0...35 (LK1023 + E43101: 0...60)	0...70	200	LK1023

Evaluation units for temperature sensors

Type	Measuring range [°C]	Process connection	Display	U _b [V]	Current consumption [mA]	I _{load} [mA]	Order no.
	-40...300	G ½ male	Display unit	18...32	50	250	TR7432


Hatch monitoring at silos



Hatch control in steel production

In secondary metallurgy metals such as nickel, cobalt or molybdenum are added to the primary steel. This material comes onto the conveyor belts through hatches. Inductive sensors monitor these hatches.

Inductive sensors for position control

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M18 / L = 46	8 f	Brass	10...30	IP 67	300	100	IG5200

f = flush / nf = non flush


Level monitoring at silos



Level detection at a silo

Capacitive sensors on the silos detect whether sufficient material is available for the metallurgical processes.

Capacitive sensors for level detection

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M18 / L = 110	8 nf	PBT	10...36	IP 65	50	250	KG5041

f = flush / nf = non flush


Slide monitoring at silos



Pneumatic slides

The silos can be completely closed using pneumatically actuated slides. The slides are monitored using magnetic sensors from ifm.

Cylinder sensors for monitoring hydraulic and pneumatic cylinders

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	25 x 5 x 6.5	f	PA (polyamide)	10...30	IP 65 / IP 67	10000	100	MK5101

f = flush / nf = non flush


Slag detection at a shroud tube manipulator



Vibration analysis at a shroud tube manipulator

Only molten steel is allowed to flow through the shroud tube into the ladle. Thanks to vibration analysis at the shroud tube manipulator it can be detected whether slag has already flown into the tube of the manipulator.

Vibration monitoring systems

Type	Description	Order no.
	Accelerometer · for connection to external diagnostic electronics type VSE · Connector · housing: stainless steel 316L / 1.4404	VSA101


Central compressed air supply



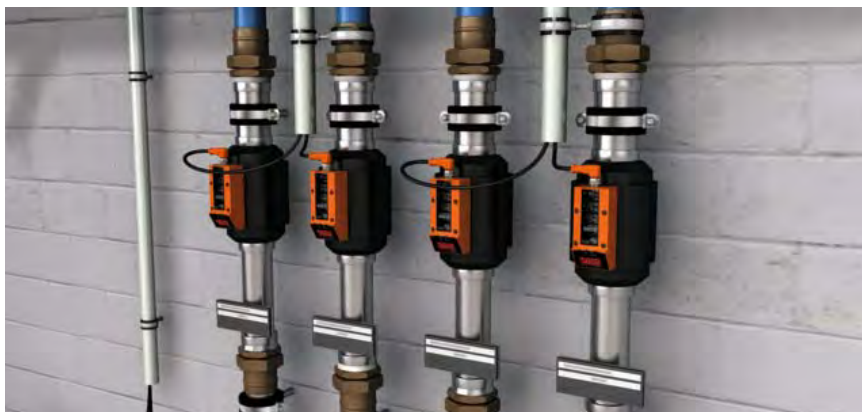
Pressure monitoring at a pressure accumulator

In the central compressed air monitoring system compressed air is temporarily stored in a tank. Electronic pressure sensors monitor the pressure which can be read out easily thanks to the analogue display.

Pressure sensors for monitoring the system pressure

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G ½	Display unit	-1...25	100	300	18...32	PG2453



Energy efficiency with compressed air



Detection of compressed air in main supply lines

Here, compressed air meters from ifm detect consumption in the pressure systems. Leakage can also be detected.

Compressed air meters for consumption measurement and leakage detection

Type	Process connection	Setting range [Nm ³ /h]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	R2 (DN50)	5...700	16	< 0.1	18...30	SD2000
	R1½ (DN40)	3.5...410.0	16	< 0.1	18...30	SD9000


Monitoring at an air dryer



Dry compressed air for pneumatic consumers

Humidity in compressed air can damage pneumatic consumers in the long run. Therefore compressed air is dried after it has been generated. ifm's humidity sensor is used to monitor the relative humidity of compressed air.

Oil humidity sensor

Type	Process connection	Pressure rating [bar]	Protection	Medium temperature oil [°C]	Ambient temperature [°C]	Order no.
	G ¾	10	IP 67	-20...100	-20...85	LDH100


Flow rate in cooling circuits at an electric arc furnace



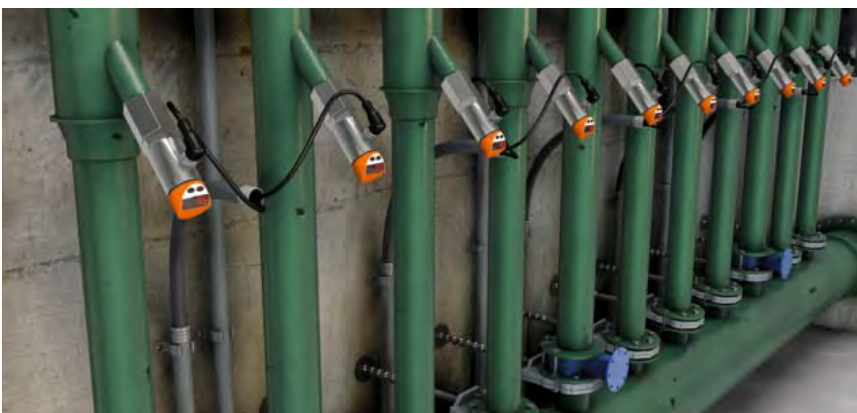
Monitoring of cooling circuits for flow rate at an electric arc furnace

Electric furnaces have cooling circuits in the outer walls and in the lid. In order to ensure a reliable operation of the blast furnaces these cooling circuits are monitored using electronic flow sensors.

Flow sensors for monitoring cooling circuits

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	3...300 / 200...3000	stainless steel 316L / 1.4404	-25...80	30	1...10	19...36	SI5000


Temperature in cooling circuits at an electric arc furnace




Monitoring of cooling circuits for temperature at an electric arc furnace

To ensure cooling of the electric furnace the temperature of the water is monitored in the various cooling circuits.

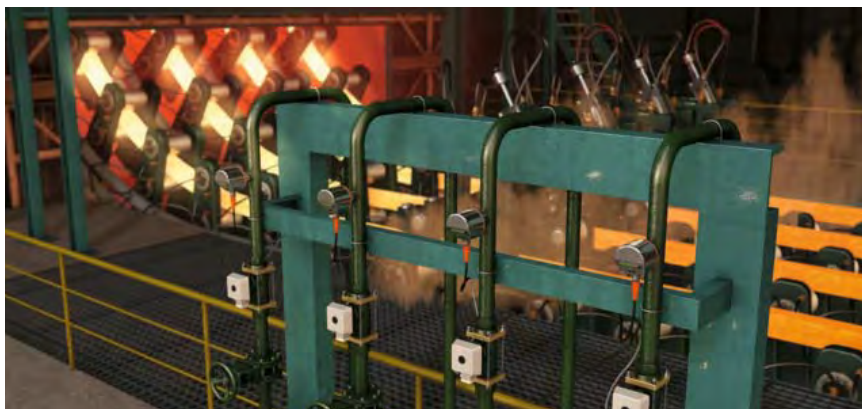
Evaluation units for temperature sensors

Type	Measuring range [°C]	Process connection	Display	U _b [V]	Current consumption [mA]	I _{load} [mA]	Order no.
	-40...300	G ½ male	Display unit	18...32	50	250	TR2432

Evaluation units for temperature sensors

Type	Measuring range [°C]	Diameter [mm]	Installation length [mm]	Sensor element	Dynamic response T05 / T09 [s]	Order no.
	-40...150	10	160	1 x Pt 1000	1 / 3	TT1050

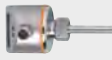
Cooling in continuous casting plants



Spray cooling in continuous casting plants

After the steel has been poured into the mould in the continuous casting plant it must be cooled. This is done by means of an air / water mixture. Flow sensors monitor the supplied quantity of water.

Flow sensors

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	3...300 / 200...3000	3...100 / 200...800	-25...80	300	1...2 / 1...10	18...36	SI5010

Positioning at a flame cutter



High-temperature applications up to 180 °C

At the end of the process the slabs or billets cast in the continuous casting plant are cut to the requested length using a flame cutter. Positioning is monitored using inductive sensors.

Inductive sensors for position feedback

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M18 / L = 70	5 f	stainless steel	10...35	IP 65	400	150	IG6614

f = flush / nf = non flush


Gas pressure monitoring in flame cutters



Industrial gas monitoring

At the end of the continuous casting plant the flame cutters are supplied with natural gas and oxygen. To ensure process reliability of the installation the supply of the industrial gases is monitored using electronic pressure sensors.

Pressure sensors for gas monitoring

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G ¼ female	Switching status	0...10	50	150	18...30	PN7024


Gas supply in flame cutters



Monitoring of valve actuators


The supply of the flame cutters with industrial gases can be interrupted by means of valve actuators. This is, for example, necessary during maintenance. These actuators are monitored using inductive dual sensors.

Inductive dual sensors for position feedback on pneumatic valve actuators

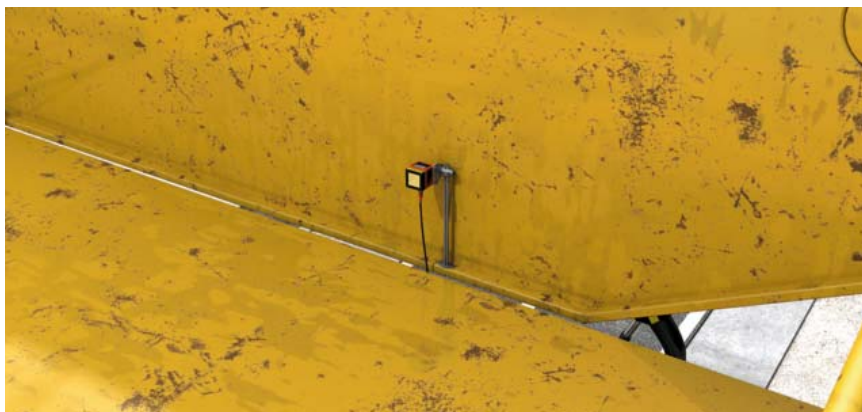
Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f AC / DC [Hz]	I _{load} AC / DC [mA]	Order no.
	40 x 26 x 26	4 nf	PBT	10...36	IP 67	1300	250	IN5225

f = flush / nf = non flush

Accessories

Type	Description	Order no.
	Target puck · Ø 102 mm · Housing materials: Target puck: PA 6 / screws: V2A	E17328


Collision avoidance in crane installations




Several cranes on a crane bridge

Two or more cranes on a crane bridge pose the risk of collision. A laser distance sensor is used to measure the distance between the cranes. If the distance is too short, the crane travel is stopped.

PMDLine photoelectric sensors with time of flight measurement

Type	Operating principle	Range	Sampling rate [Hz]	Spot Ø at max. range [mm]	U _b [V]	Order no.
	Photoelectric distance sensor	1...100 m	1...25	< 200 x 200	18...30	O1D209

Accessories

Type	Description	Order no.
	Prismatic reflector · 226 x 262 mm · rectangular · Housing materials: plastics	E21159


Reliable area monitoring at crane installations



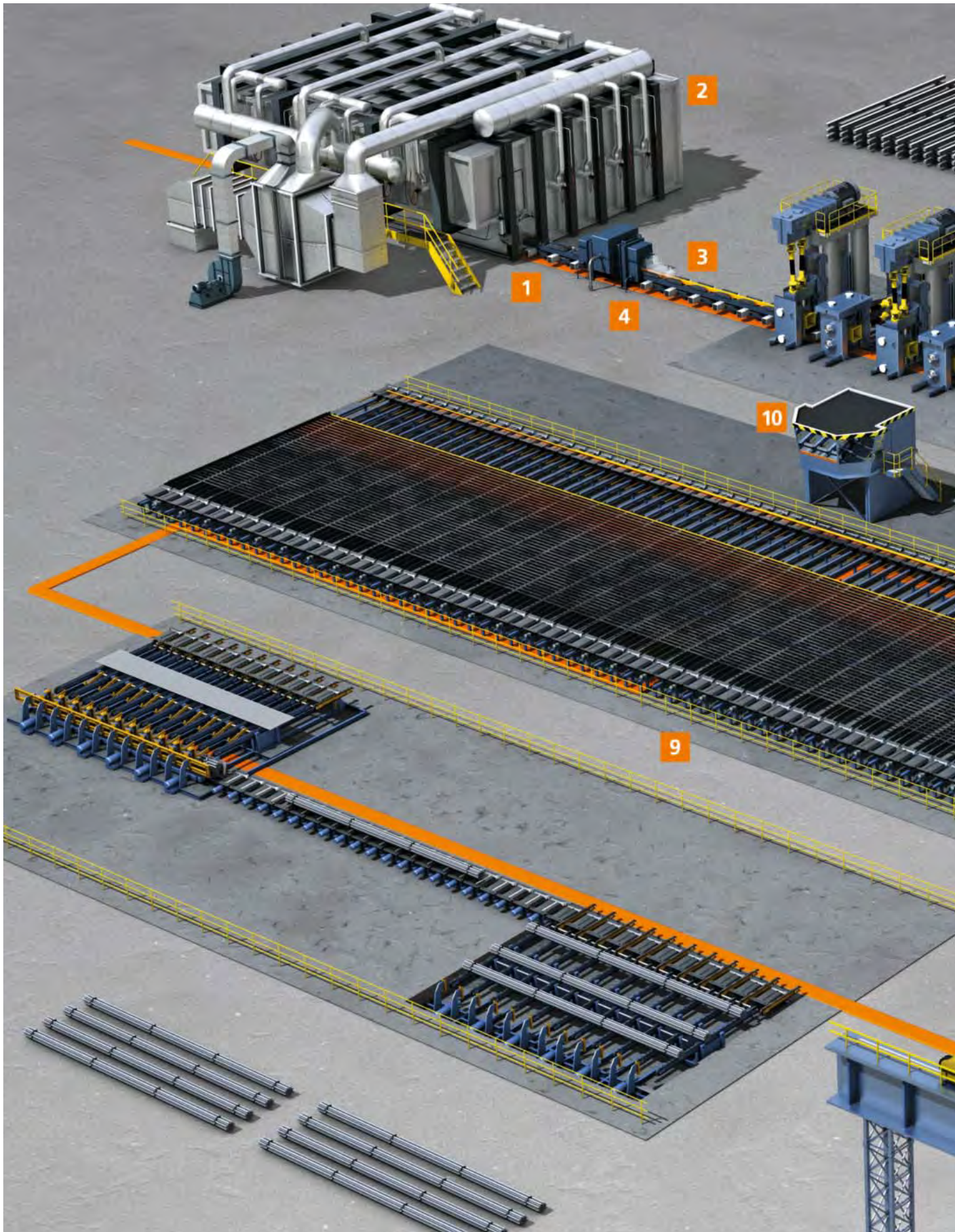
Limitation of the trolley travel on crane installations

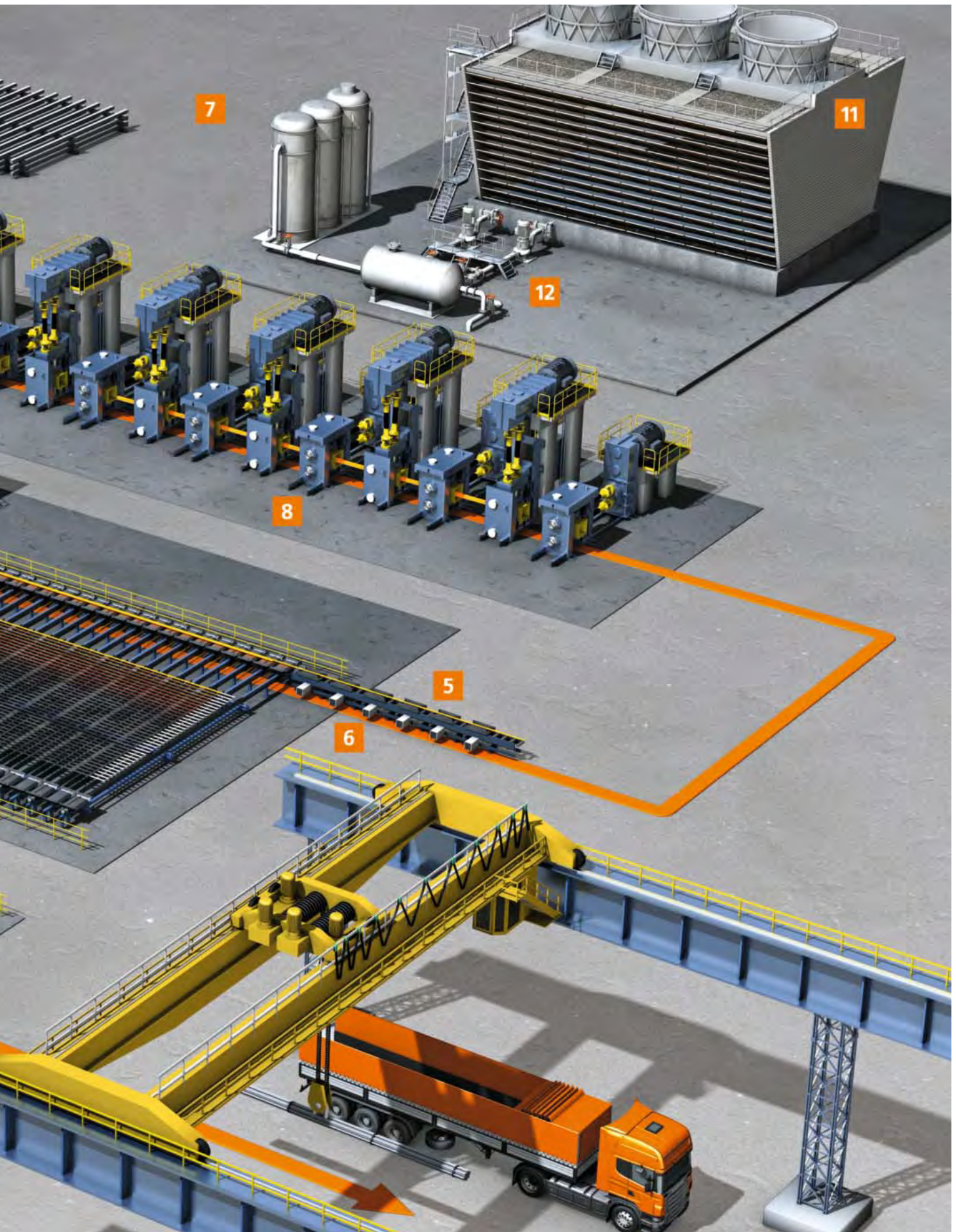
By means of a fail-safe inductive sensor and a metal rail the trolley travel of cranes can be limited.







Fail-safe inductive sensors







Type	Length [mm]	Enable zone [mm]	Housing material	U _b DC [V]	Protection	Response time in case of a safety request / enable time [ms]	Order no.
	66	10...15 nf	PPE	24	IP 65 / IP 67	≤ 50 / ≤ 200	GM701S

f = flush / nf = non flush





Machine	Application	Product group
1 Positioning on the heating furnace		
	Monitoring the material at the inlet side of the furnace	Laser sensors / distance measurement sensors
	Monitoring the material at the outlet side of the furnace	Temperature sensors
	Position detection of a furnace door	Inductive sensors
2 Cooling circuits on furnaces		
	Flow monitoring	Flow sensors / flow meters
	Temperature monitoring	Temperature sensors
	Pressure monitoring	Pressure sensors
	Connection of sensors	Sockets
3 High-pressure pump in descaling lines		
	Pressure monitoring	Pressure sensors
	Position detection of shut-off valves	Inductive sensors
	Temperature monitoring	Temperature sensors
	Bearing monitoring	Vibration monitoring systems
4 Tracking of material in descaling lines		
	Position detection of nozzles	Laser sensors / distance measurement sensors
	Monitoring of material	Temperature sensors
	Position detection on doors	Inductive sensors
	Level monitoring	Level sensors
5 Decentralised monitoring in large installations		
	Voltage supply in the field	Power supplies
	Speed measurement	Pulse evaluation systems
	Vibration monitoring	Vibration monitoring systems
	Pulse generator	Inductive sensors
6 Speed monitoring at conveyors		
	Rotational speed monitoring	Pulse evaluation systems
	Rotational speed monitoring	Encoders
	Connection of sensors	Sockets

Machine	Application	Product group
7 Compressed air supply		
	Pressure monitoring	Pressure sensors
	Measurement of compressed air consumption	Flow sensors / flow meters
	Monitoring of remaining humidity	Systems for oil quality monitoring
	Pressure indication in the installation	Pressure sensors
8 Drive monitoring on the rollers		
	Temperature monitoring	Temperature sensors
	Condition monitoring of drives	Vibration monitoring systems
	Rotational speed monitoring	Pulse evaluation systems
9 Cooling bed		
	Tracking of material	Inductive sensors
	Monitoring of material	Laser sensors / distance measurement sensors
	Protection of sensors	Sockets
	Condition monitoring of drives	Vibration monitoring systems
10 Hydraulic aggregates		
	Pressure monitoring	Pressure sensors
	Temperature monitoring	Temperature sensors
	Level monitoring	Level sensors
	Oil condition monitoring	Systems for oil quality monitoring
11 Fans in cooling towers		
	Vibration monitoring	Vibration monitoring systems
	Temperature monitoring	Temperature sensors
	Rotational speed monitoring	Pulse evaluation systems
12 Cooling towers		
	Pressure monitoring	Pressure sensors
	Flow monitoring	Flow sensors / flow meters
	Level monitoring	Level sensors
	Vibration monitoring	Vibration monitoring systems

ifm sensors carry out their tasks even in tough environments



In a hot rolling mill slabs, blooms or billets produced in steelworks are processed further. To do so, they are heated up to a temperature above the recrystallisation temperature.

Depending on the starting material, long steel products (such as wires, rails or beams) or wide flat steel products (e.g. sheet metal) are made in hot rolling mills. These semi-finished products are then processed further in subsequent processes.

As a result of the high temperatures and harsh environmental conditions the sensors used must meet higher demands than in other industries. Robust sensors with extended temperature range from ifm reliably detect the relevant parameters even in these harsher conditions.

Here, ifm sensors help to ensure high plant uptime in the event of extreme environmental influences.


Monitoring the material at the inlet side of the furnace




Detecting the position of the billets at the inlet side of the furnace

The door at the inlet side of the furnace is closed when the billet is completely inside the furnace. The position of the billet is detected using a laser distance measurement sensor.

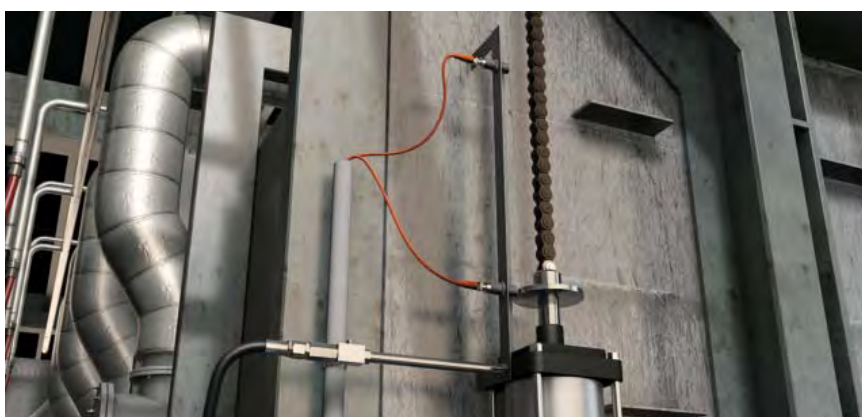
PMDLine photoelectric sensors with time of flight measurement

Type	Operating principle	Range	Sampling rate [Hz]	Spot Ø at max. range [mm]	U _b [V]	Order no.
	Photoelectric distance sensor	0.2...10 m	1...50	< 15 x 15	18...30	O1D100

Protective housing for distance measurement sensors

Type	Description	Order no.
	Cooling box · Protective housing with an active cooling system for the O1D design · for type O1D · Housing materials: housing: aluminium transparent anodised / cover: aluminium black anodised / bezel: aluminium black anodised / window: float glass / cable gland: Brass nickel-plated / nozzle: Brass nickel-plated / sealing: FPM	E21248

Monitoring of the furnace door



Monitoring the door at the outlet side of the furnace

Via a cylinder the door is moved at the outlet side of the furnace. This happens indirectly via a chain. The position of the door is monitored using high-temperature inductive sensors.

Inductive sensors for determining position

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M18 / L = 70	5 f	stainless steel	10...35	IP 65	400	150	IG6614

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Monitoring the material at the outlet side of the furnace



Detecting hot billets at the outlet side of the furnace

After a hot billet has moved out of the furnace the door must be closed again. An infrared sensor detects that the billet is no longer in the door area.

Infrared temperature sensors for the detection of material

Type	Temperature range [°C]	Wave length range [µm]	Material lens	Response time [ms]	Order no.
	250...1250	1.0...1.7	tempered optical glass	≤ 2	TW7001


Measurement of the cooling water volume




Monitoring of the cooling circuits

Cooling circuits must be operated with a defined quantity of water. This is monitored using flow sensors. They ensure that the quantity is not too small.

Flow sensors for monitoring cooling circuits

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	8...600	stainless steel 316L / 1.4404	-10...70	16	< 0.35	18...32	SM2000

Connectors

Type	Description	Order no.
	Socket · straight · Free from silicone · Free from halogen · Gold-plated contacts · For welding applications · M12 connector · 5 m · Housing materials: housing: TPU orange / sealing: FKM	EVW002


Pressure monitoring of the lubrication



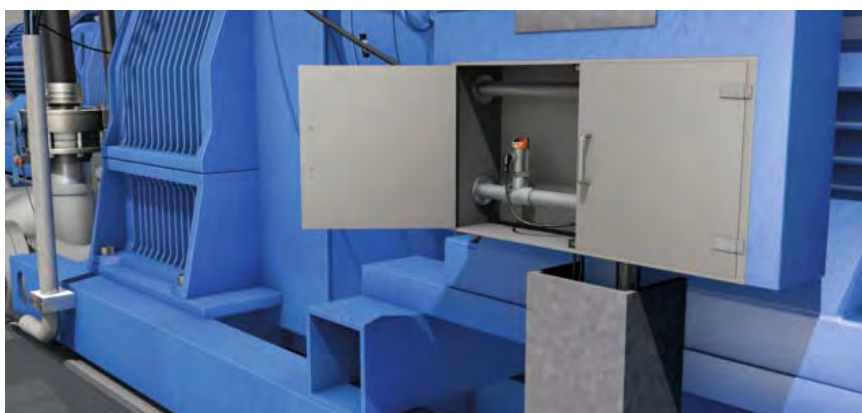
Pressure monitoring at the lubrication of the high-pressure pumps

The high-pressure pumps of the descaling lines are continuously lubricated by means of a separate oil circuit. The pressure in this circuit is continuously monitored.

Pressure monitoring in descaling lines

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G ¼ female	Display unit	0...25	150	350	18...30	PN7093


Temperature monitoring of the lubrication




Temperature monitoring at the lubrication of the high-pressure pumps

The lubricity of oils depends on the oil temperature. The temperature of the oil circuit is monitored using temperature sensors (TS) and displayed by the temperature monitor (TR).

Temperature monitoring in descaling lines

Type	Measuring range [°C]	Diameter [mm]	Cable material	Sensor element	Dynamic response T05 / T09 [s]	Order no.
	-40...90	Ø 10	PUR cable	1 x Pt 100	6 / 25	TS5089

Evaluation units for temperature sensors

Type	Measuring range [°C]	Process connection	Display	U _b [V]	Current consumption [mA]	I _{load} [mA]	Order no.
	-40...300	G ½ male	Display unit	18...32	50	250	TR2432


Monitoring of shut-off valves



Effective pump protection

The shut-off valves in the intake of the high-pressure pumps of the descaling line are manually operated. An inductive sensor detects the valve position and prevents unintentional switch-on of the high-pressure pump in the event of a closed intake.

Inductive sensors for determining position

Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f [Hz]	I_{load} [mA]	Order no.
	M30 / L = 60	22 nf	Brass	10...30	IP 65 / IP 66 / IP 67 / IP 68 / IP 69K	100	100	IIS227

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Detection of material at the descaling line



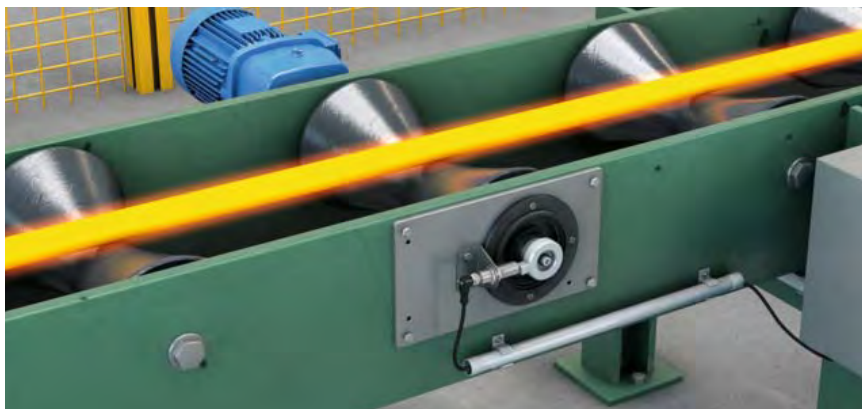
Control of the water jet in the descaling line

An infrared temperature sensor is used to detect the hot billet before the descaling line. The water supply to the nozzles is opened via a switching signal.

Infrared temperature sensors for the detection of material

Type	Temperature range [°C]	Wave length range [μm]	Material lens	Response time [ms]	Order no.
	250...1250	1.0...1.7	tempered optical glass	≤ 2	TW7001


Speed monitoring at conveyors



Transport of rolled bars or rods

The compact speed monitor detects pulses on the drive shaft of the roller conveyor. The monitor is an inductive sensor with integrated speed evaluation.

Compact speed monitor for pulse detection

Type	Dimensions [mm]	Sensing range [mm]	Electrical design	U_b [V]	Setting range [puls. / min.]	Start-up delay [s]	Order no.
	M30 / L = 82	10 f	DC PNP	10...36 DC	5...300	15	DI5009

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Decentralised speed monitoring



Detecting speed, standstill and acceptable range

The speed monitor evaluates the signals from one or several inductive sensors. It has one switch point for monitoring underspeed / overspeed and one for monitoring the acceptable range.

Speed monitor for pulse evaluation

Type	U_b [V]	In- puts	Input function	Setting range [puls. / min.]	Setting range [Hz]	Out- puts analogue	Out- puts relays	Out- puts transist.	Order no.
	110...240 AC (50...60 Hz) / 27 DC (typ. 24 DC)	2	PNP / NPN / Namur	1...60000	0.1...1000	–	2	2	DD2505


Pulse pick-ups for speed monitoring



Control of the roller conveyor

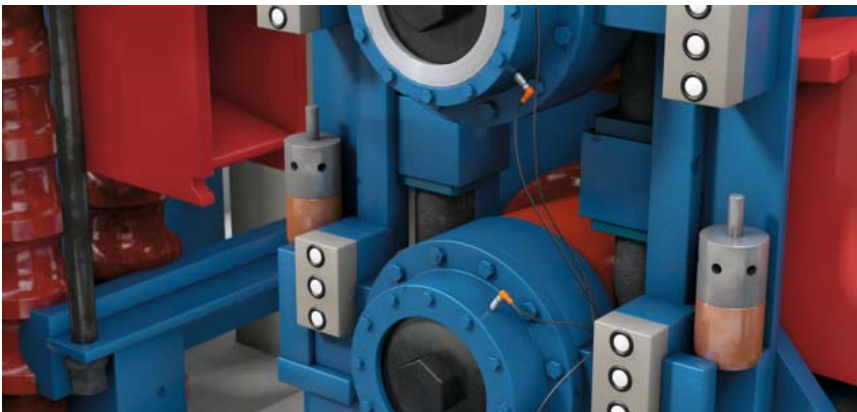
The speed of all drives of the roller conveyor is synchronised and controlled. An inductive sensor detects the switching cam mounted on the shaft, generating the pulses for a downstream speed monitoring.

Inductive sensor as pulse pick-up

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M18 / L = 60	8 f	Brass	10...30	IP 65 / IP 66 / IP 67 / IP 68 / IP 69K	400	100	IGS232

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Vibration sensors on bearings




Monitoring bearings in the hot rolling area

Vibration sensors monitor the bearings of the roller stands. The sensor measures the rms vibration velocity and transmits the value as current signal to the process control system.

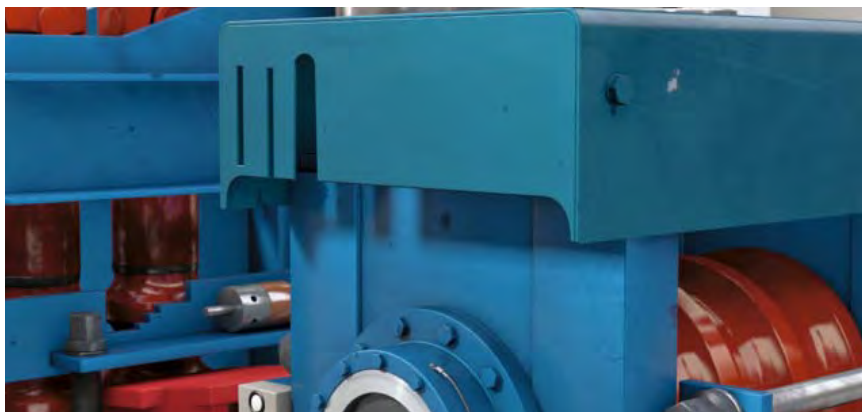
Vibration monitoring systems

Type	Description	Order no.
	Accelerometer · for connection to external diagnostic electronics type VSE · Connector · housing: stainless steel 316L / 1.4404	VSA001

Connectors

Type	Description	Order no.
	Jumper · straight / straight · Free from silicone · Free from halogen · Gold-plated contacts · For welding applications · 1 m · Housing materials: housing: TPU orange / sealing: FKM	EVW024


Temperature monitoring of bearings




Temperature measurement of bearings

Besides vibration, the housing temperature of a bearing in the hot rolling area is indicative of the machine condition. A bolt-on sensor (TS) detects the temperature which is processed and displayed in the evaluation unit (TR).

Temperature sensors

Type	Measuring range [°C]	Diameter [mm]	Cable material	Sensor element	Dynamic response T05 / T09 [s]	Order no.
	-25...90	12 x 8.7 x 51	PUR cable	1 x Pt 100	9 / 15	TS2229

Evaluation units for temperature sensors

Type	Measuring range [°C]	Process connection	Display	U _b [V]	Current consumption [mA]	I _{load} [mA]	Order no.
	-40...300	G ½ male	Display unit	18...32	50	250	TR7432


Monitoring the remaining humidity in compressed air



Monitoring the compressed air drying

After compression in the compressor the compressed air cools down. The steam condensed in this process is removed using a downstream dryer. The humidity sensor measures the relative humidity and temperature of the compressed air and provides these as analogue values.

Oil humidity sensor

Type	Process connection	Pressure rating [bar]	Protection	Medium temperature oil [°C]	Ambient temperature [°C]	Order no.
	G ¾	10	IP 67	-20...100	-20...85	LDH100


Compressed air measurement at the compressed air distribution



Detection of compressed air in main supply lines

Here, compressed air meters detect the volume flow both in the normal pressure (6 bar) and high-pressure system (12 bar). So both consumption and leakage are detected.

Compressed air meters for consumption measurement and leakage detection

Type	Process connection	Setting range [Nm ³ /h]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	R2 (DN50)	5...700	16	< 0.1	18...30	SD2000


Pneumatics




Monitoring the maintenance unit

Here, pressure sensors with the easy-turn operating concept monitor the correct operating pressure in the compressed air supply. The innovative SD compressed air meter determines consumption.

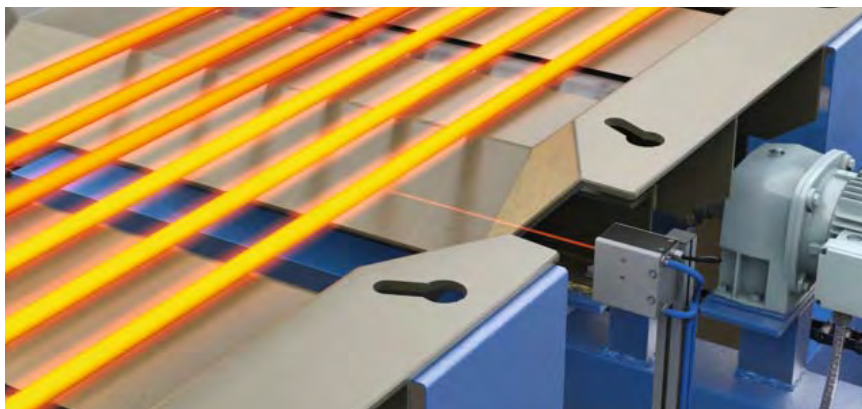
Pressure sensors

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G¼ male / M5 female	Operation	0...10	25	300	9.6...32	PK6524

Compressed air meter for the measurement of compressed air consumption

Type	Process connection	Setting range [Nm ³ /h]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	R½ (DN15)	0.6...75.0	16	< 0.1	18...30	SD6000


Protection of sensors




Protection at a high ambient temperature

At ambient temperatures up to 180 °C the electronics of the laser distance measurement sensors is protected from overheating using a cooling box. In addition, it ensures a reliable mechanical protection for photoelectric sensors.

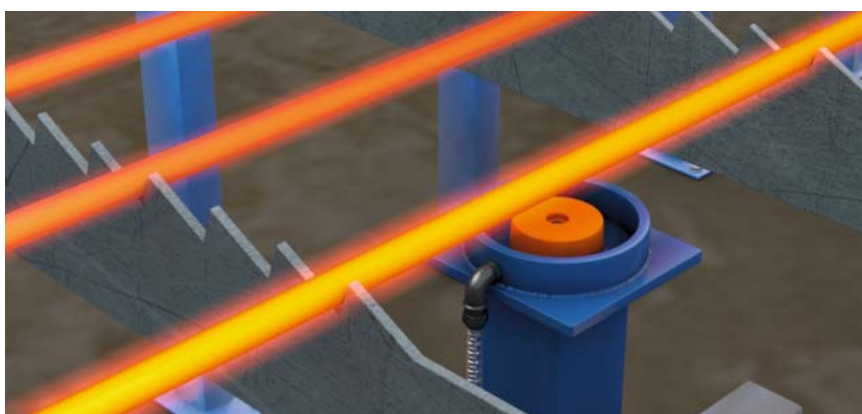
Protective housing for distance measurement sensors

Type	Description	Order no.
	Cooling box · Protective housing with an active cooling system for the O1D design · for type O1D · Housing materials: housing: aluminium transparent anodised / cover: aluminium black anodised / bezel: aluminium black anodised / window: float glass / cable gland: Brass nickel-plated / nozzle: Brass nickel-plated / sealing: FPM	E21248

PMDLine photoelectric sensors with time of flight measurement

Type	Operating principle	Range	Sampling rate [Hz]	Spot Ø at max. range [mm]	U _b [V]	Order no.
	Photoelectric distance sensor	0.2...10 m	1...50	< 15 x 15	18...30	O1D100


Tracking of material in the cooling bed



Long distance to hot steel

In cooling beds inductive sensors, among others, are used to detect the produced material. The sensors have sensing ranges up to 120 mm to ensure a long distance to the material.

Inductive sensors with long sensing ranges

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	Ø 100	70 nf	PBT	10...36	IP 65	5	250	I17001

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Vibration monitoring at the cooling bed



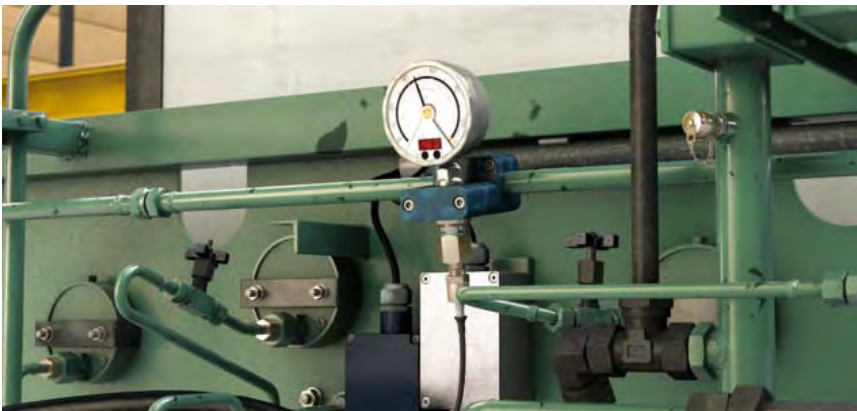
Avoiding machine damage

Vibration monitors monitor the drives of the roller conveyor. The sensor measures the rms vibration velocity and transmits the value as current signal to the process control system.

Vibration sensors for bearing monitoring in drives

Type	Description	Order no.
	Vibration monitor · Connection via M12 connector · Vibration monitor to DIN ISO 10816 · Measuring range RMS: 0...25 mm/s · Switching output NC DC PNP and analogue output 4...20 mA · Housing materials: PBT / PC / FPM / stainless steel 316L / 1.4404	VKV021


Pressure monitoring in hydraulic power packs



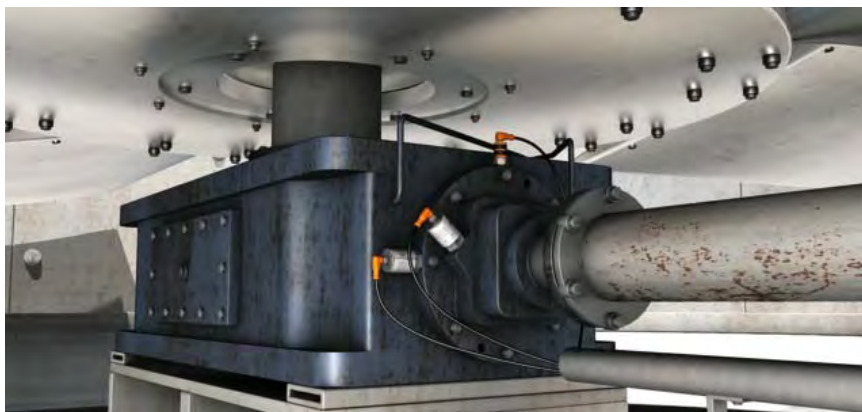
Electronic contact manometer in hydraulics

The system pressure at the hydraulic power pack must be monitored continuously. The electronic contact manometer combines an easy-to-read analogue display with the advantages of an electronic pressure sensor.

Pressure sensors for monitoring the system pressure

Type	Process connection	Display	Measuring range [bar]	Poverload max. [bar]	Pbursting min. [bar]	U _b DC [V]	Order no.
	G ½	Display unit	-1...25	100	300	18...32	PG2453


Oil temperature at the gear of the fan



Differential temperature measurement

The difference between the start and end temperature of the oil is indicative of the gear condition. A defined preset value must not be exceeded. Temperature sensors detect the oil temperatures reliably and precisely.

Temperature sensors

Type	Factory setting [°C / °F]	Process connection	Installation length [mm]	U _b [V]	Dynamic response T05 / T09 [s]	Order no.
	-50...150 / -	G ½	30	18...32	1 / 3	TA2405


Vibration sensors at the fan



Monitoring fans for imbalance

Vibration sensors monitor the gear at a fan of the cooling tower. When a limit value to be set is exceeded a switching contact is triggered.

Vibration sensor for bearing monitoring

Type	Description	Order no.
	Vibration monitor · Connection via M12 connector · Vibration monitor to DIN ISO 10816 · Measuring range RMS: 0...25 mm/s · Switching outputs: normally closed and analogue 4...20 mA · Housing materials: PBT / PC / FPM / stainless steel 316L / 1.4404	VKV021


Vibration monitoring at pumps



Condition monitoring at pumps

Vibration sensors detect the vibration generated by pumps. This allows condition-based maintenance. The sensor is specifically used for measured data acquisition for the VSE type diagnostic electronics.

Vibration monitoring systems

Type	Description	Order no.
	Accelerometer · for connection to external diagnostic electronics type VSE · Connector · housing: stainless steel 316L / 1.4404	VSA001


Drive monitoring at pumps



Diagnostic electronics for pump sensors

The diagnostic electronics enables to simultaneously analyse the measured signals of up to four vibration sensors. To do so, up to eight digital and two analogue sensors can be connected, monitoring the complete pump station.

Vibration monitoring systems

Type	Description	Order no.
	Diagnostic electronics for vibration sensors · Integrated history memory with real-time clock · Counter function · TCP/IP Ethernet interface · Active wire break detection and self-test (only MEMS) of the connected acceleration sensors · Parameter setting via PC software VES004 · Combicon connection · PA	VSE100


Monitoring the cooling water at cooling towers




Cooling water supply in the steelworks

To ensure that enough cooling water is available in the production process both flow rate and pressure of the water are detected.

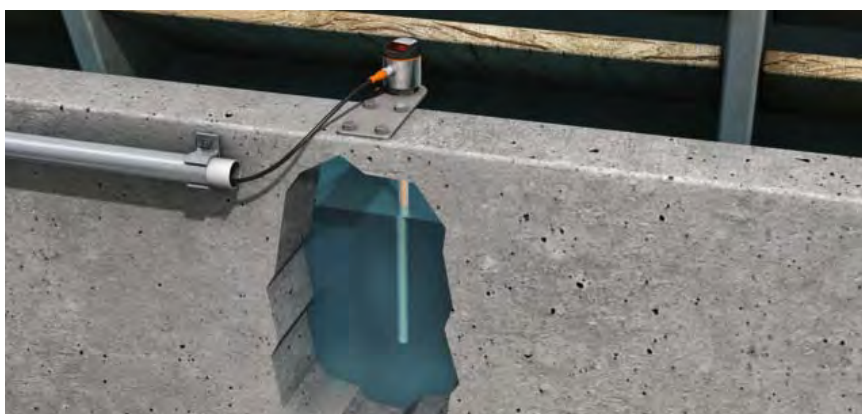
Flow sensors for monitoring cooling circuits

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	3...300 / 200...3000	stainless steel 316L / 1.4404	-25...80	30	1...10	19...36	SI5000

Pressure sensors for monitoring the system pressure

Type	Process connection	Display	Measuring range [bar]	Poverload max. [bar]	Pbursting min. [bar]	U _b DC [V]	Order no.
	G ½	Display unit	-1...10	50	150	18...32	PG2454


Level monitoring in the cooling tower



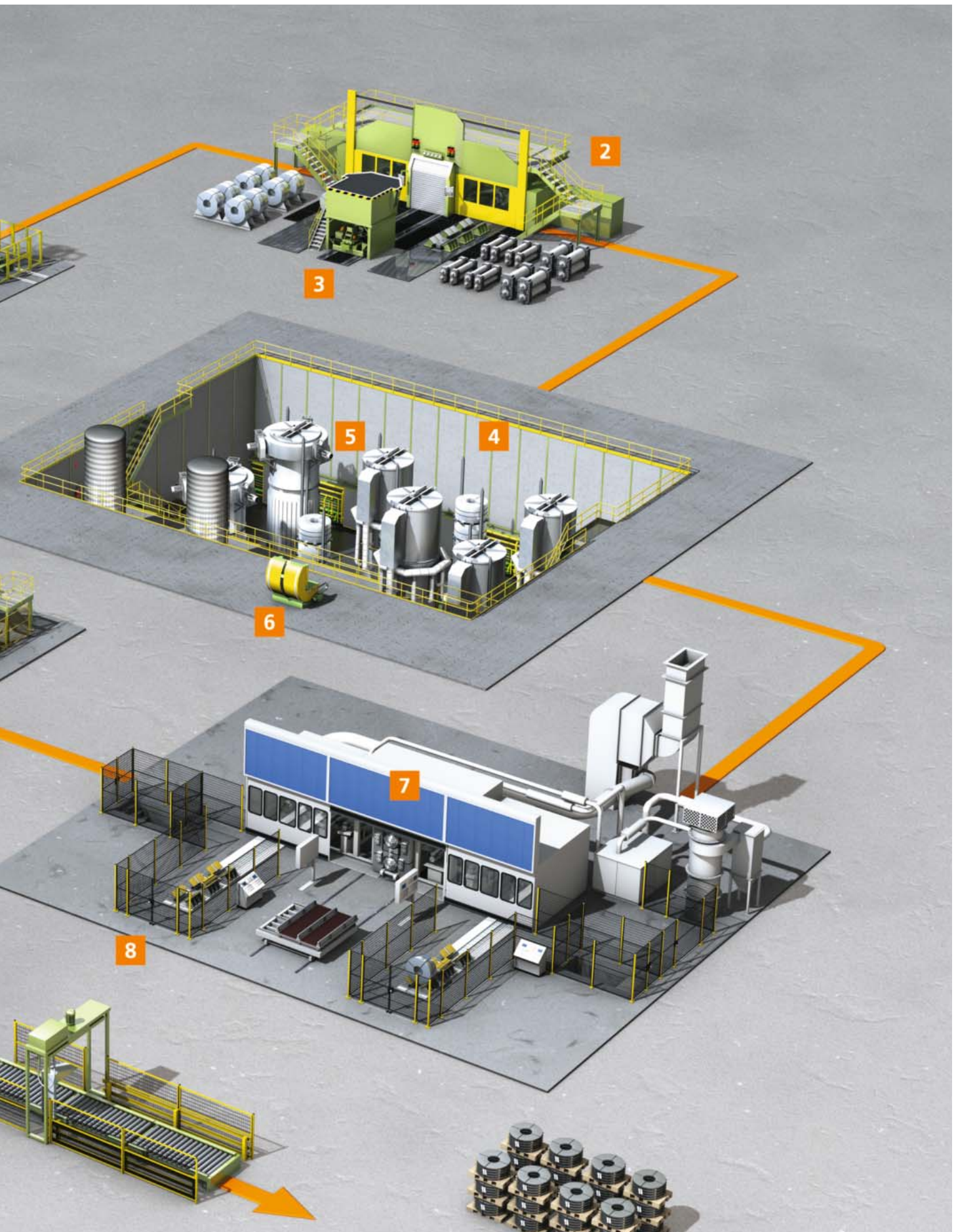
Optimum level in the basin of the cooling tower



Cooling water circuits are supplied with water from the basin of the cooling tower. The heated water is pumped back with fresh water replacing the losses. The optimum level is ensured by a level sensor.

Level sensors

Type	Probe length [mm]	Active zone [mm]	Inactive zone [mm]	U _b [V]	Medium temperature water [°C]	Medium temperature oil [°C]	I _{load} [mA]	Order no.
	728	585	102 / 40	18...30	0...35 (LK3124 + E43102: 0...55)	0...70	200	LK3124





Machine	Application	Product group
1 Suction in the pickling line		
	Speed measurement	Pulse evaluation systems
	Vibration monitoring	Vibration monitoring systems
	Airflow monitoring	Flow sensors / flow meters
2 Roller stand drive		
	Vibration monitoring	Vibration monitoring systems
	Temperature measurement	Temperature sensors
	Voltage supply	Power supplies
	Speed measurement	Pulse evaluation systems
3 Roller replacement cars		
	Hydraulic system pressure detection	Pressure sensors
	Level monitoring in hydraulic power packs	Level sensors
	Temperature measurement in hydraulic power packs	Temperature sensors
	Position detection of replacement cars	Inductive sensors
4 Annealing furnace		
	Pressure monitoring protective gas	Pressure sensors
	Detection of equipment parts	Inductive sensors
	Monitoring of cooling water	Flow sensors / flow meters
	Vibration monitoring	Vibration monitoring systems
5 Annealing furnace supply unit		
	Pressure monitoring protective gas	Pressure sensors
	Monitoring of quarter-turn actuators	Inductive sensors
	Monitoring of cooling water	Flow sensors / flow meters
	Pressure monitoring of natural gas	Pressure sensors
6 Upender		
	End position monitoring	Inductive sensors
	Position detection of fixing bolts	Inductive sensors
	Position detection of coil	Photoelectric sensors for general applications

Machine	Application	Product group
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7 Position monitoring in roller stand



Position detection of transfer table	Cylinder sensors
Detecting the stop	Inductive sensors
Photoelectric detection of unwinding coil	Laser sensors / distance measurement sensors
Position detection of lifting carriage	Inductive sensors

8 Access control / securing the area



Monitoring of high-speed doors	Inductive sensors
Door protection	AS-Interface Safety at Work
Safety monitoring	Safety light curtains

9 Slitting line



Position detection of shear stand	Inductive sensors
Photoelectric detection of sag	Laser sensors / distance measurement sensors
Belt centring control	Flow sensors / flow meters
Cutting of sheets	Encoders

10 Roller conveyor systems



Tracking of material	Photoelectric sensors for general applications
Speed measurement	Pulse evaluation systems
Safety monitoring	Safety light curtains
Position detection of rotary table	Inductive sensors

11 Temporary coil store



Occupation of storage location	Photoelectric sensors for general applications
Position check of positioning carriage	Inductive sensors
Hydraulic system pressure detection	Pressure sensors
Temperature measurement	Temperature sensors

12 Packaging machine



Centring of coils	Inductive sensors
Detection of material on the electromagnet	Inductive sensors
Tracking of material	Photoelectric sensors for general applications
Safety monitoring	Safety light curtains

Reliable sensors increase plant uptime



In the cold rolling mill sheets are usually supplied as coils and then reduced to the requested thickness by rolling the material. The starting material, usually hot-rolled wide strip, is first descaled and then the cross-section is reduced by the rolling process. When the sheet has achieved its final thickness, it is cut to the requested width and then packed and dispatched. Markets are, among others, the automotive industry / suppliers, pipe manufacturers and the electrical white goods.


The demand on reliability and machine uptime is extremely high in usually very rough environmental conditions (aggressive chemicals in pickling lines, shocks and vibrations in rolling and shearing lines). Reliable and robust sensors from ifm meet these high demands effectively, securing sustained success.

Suction in the pickling line – fan monitoring

**Speed detection on fans**

The compact DI speed monitor detects pulses on the fan drive shaft.

Compact speed monitor for pulse detection

Type	Dimensions [mm]	Sensing range [mm]	Electrical design	U _b [V]	Setting range [puls. / min.]	Start-up delay [s]	Order no.
	M30 / L = 82	10 f	DC PNP	10...36 DC	5...300	15	DI5009

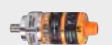
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Suction in the pickling line – bearing monitoring

**Monitoring of shaft bearings**

The compact VKV vibration sensor monitors the vibration on the bearing of a drive shaft. Too high a vibration can be detected early, avoiding machine damage.

Vibration sensors for bearing monitoring in drives

Type	Description	Order no.
	Vibration monitor · Connection via M12 connector · Vibration monitor to DIN ISO 10816 · Measuring range RMS: 0...25 mm/s · Switching output NC DC PNP and analogue output 4...20 mA · Housing materials: PBT / PC / FPM / stainless steel 316L / 1.4404	VKV021


Vibration monitoring on the roller drive



Condition monitoring of drives

VSA series sensors record the vibration levels of the drives, enabling condition-oriented maintenance.

Vibration monitoring systems

Type	Description	Order no.
	Accelerometer · for connection to external diagnostic electronics type VSE · Connector · housing: stainless steel 316L / 1.4404	VSA001


Drive monitoring in a rolling installation




Evaluation of the drive monitoring on the roller drive

The vibration data provided by the VSA sensors is automatically evaluated in the VSE diagnostic electronics. The current equipment condition can be transferred directly to higher-level systems.

Vibration monitoring systems

Type	Description	Order no.
	Diagnostic electronics for vibration sensors · Integrated history memory with real-time clock · Counter function · TCP/IP Ethernet interface · Active wire break detection and self-test (only MEMS) of the connected acceleration sensors · Parameter setting via PC software VES004 · Combicon connection · PA	VSE100

Speed monitor for drive monitoring

Type	U _b [V]	In-puts	Input function	Setting range [puls. / min.]	Setting range [Hz]	Out-puts analogue	Out-puts relays	Out-puts transist.	Order no.
	110...240 AC (50...60 Hz) / 27 DC (typ. 24 DC)	2	PNP / NPN / Namur	1...60000	0.1...1000	–	2	2	DD2505


Monitoring of a hydraulic power pack in roller replacement cars




Pressure and temperature monitoring in hydraulic power packs

PN and TN type sensors detect the pressure and temperature of the hydraulic oil.

Pressure sensors

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G 1/4 male / M5 female	Display unit	0...25	150	350	18...30	PN7593

Temperature sensors

Type	Measuring range [°C / °F]	Process connection	Installation length [mm]	U _b [V]	Dynamic response T05 / T09 [s]	Order no.
	-40...150 / -40...302	M18 x 1.5	45	18...32	1 / 3	TN7531


Filter monitoring in a hydraulic system



Detection of filter blockage

Pressure sensors monitor the status of an oil filter in a hydraulic power pack. If the filter is blocked, a signal is sent to the controller.

Pressure sensors

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G 1/4 male	-	0...25	60	600	8.5...36	PT3553

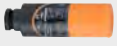
Positioning of the roller replacement car



End position monitoring on the roller replacement car

For an exact positioning of the rails on which the working rollers are pushed into the roller stand the end positions of the tool table are monitored using an inductive sensor.

Inductive sensors for tool table positioning

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	Ø 34 / L = 98	20 nf	PBT	10...36	IP 65	350	250	IB5063

f = flush / nf = non flush


End position monitoring on the upender



Positioning the upender using inductive sensors


For feeding the annealing furnaces the coils are tilted by 90°. This is done using an upender. It is controlled by a coolant-resistant sensor.

Inductive sensors for positioning the upender

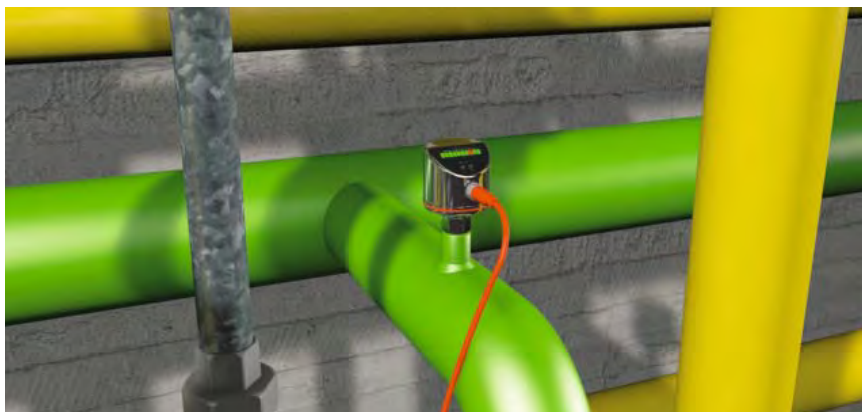
Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M12 / L = 45	4 f	Brass	10...30	IP 68	700	100	IFC200

f = flush / nf = non flush

Connectors

Type	Description	Order no.
	Socket · angled · Free from silicone · Free from halogen · Gold-plated contacts · For welding applications · M12 connector · 5 m · Housing materials: housing: TPU black transparent / sealing: FKM	EVW008


Monitoring of the cooling water for annealing furnaces



Flow rate measurement during the cooling process of the annealing furnaces

To ensure the operational reliability of annealing furnaces it is necessary to cool certain equipment parts (e.g. the base). The minimum quantity of cooling water is monitored using a flow sensor.

Flow sensors for monitoring cooling circuits

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	3...300 / 200...3000	stainless steel 316L / 1.4404	-25...80	30	1...10	19...36	SI5000


Protective gas supply for an annealing furnace



Monitoring industrial gases in an annealing furnace

Annealing furnaces operate in a protective gas atmosphere. Using pressure sensors the pressure of industrial gases is monitored.

Pressure sensors for gas monitoring

Type	Process connection	Display	Measuring range [bar]	P _{overload} max. [bar]	P _{bursting} min. [bar]	U _b DC [V]	Order no.
	G ½	Display unit	-1...10	50	150	18...32	PG2454


Control of the gas supply for an annealing furnace



Controlling the industrial gases for an annealing furnace


The supply of the annealing furnace with protective gas for the protective covers or with natural gas for the burners is controlled using valve actuators. These are monitored by means of inductive sensors.

Inductive dual sensors for position feedback on pneumatic valve actuators

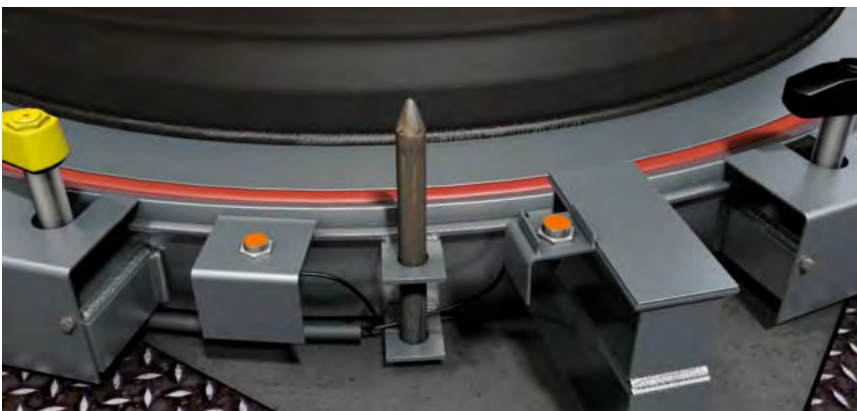
Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f AC / DC [Hz]	I_{load} AC / DC [mA]	Order no.
	40 x 26 x 26	4 nf	PBT	10...36	IP 67	1300	250	IN5225

f = flush / nf = non flush

Accessories

Type	Description	Order no.
	Target puck · Ø 102 mm · Housing materials: Target puck: PA 6 / screws: V2A	E17328


Detection of equipment parts of an annealing furnace



Distinction of various equipment parts

On the base of an annealing furnace either the furnace or a cooling cover is in operation. Depending on the cover used the base is supplied with cooling water or gas. For differentiation inductive sensors are used.

Inductive sensors for equipment control

Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f [Hz]	I_{load} [mA]	Order no.
	M30 / L = 50	15 f	Brass	10...36	IP 67	100	100	IIS204

f = flush / nf = non flush


Positioning of the transfer table




Position detection of the transfer table

Introducing a strip of the coil into a rolling installation is done automatically. By means of transfer tables the strip is positioned correctly. Cylinder sensors monitor the position of the tables.

Cylinder sensors for monitoring hydraulic and pneumatic cylinders

Type	Dimensions [mm]	Material	U _b [V]	f [Hz]	Protection	I _{load} [mA]	T _a [°C]	Order no.
	25 x 5 x 6.5	PA (polyamide)	10...30	10000	IP 65 / IP 67	100	-25...85	MK5100

Accessories

Type	Description	Order no.
	Adapter for tie rod / integrated profile cylinders · for types MKT (T-slot cylinder sensors) · Clamping range 9...15 mm · Housing materials: aluminium / screw: stainless steel	E11799


Locking of the rollers



Securing the rollers during the rolling process

Before sheets are rolled it must be ensured that the rollers are correctly positioned and mechanically locked. This is monitored using inductive sensors.

Inductive sensors for monitoring the locking of rollers

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	M18 / L = 46	8 f	Brass	10...30	IP 67	300	100	IGS200

f = flush / nf = non flush


Monitoring of high-speed doors



Door monitoring

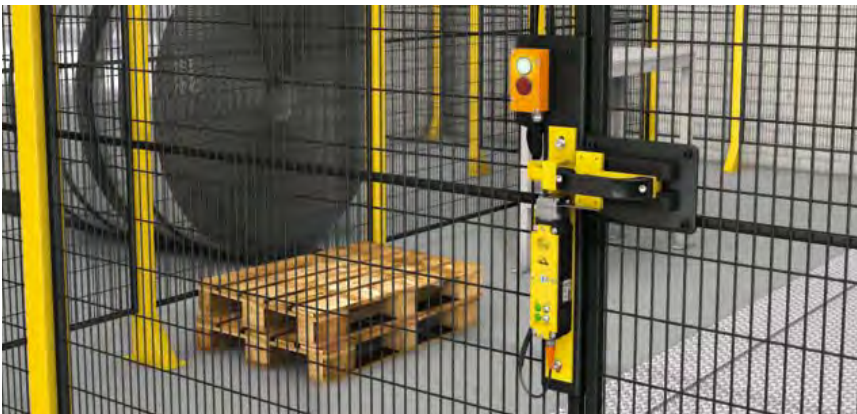
Category 4 and SIL 3 fail-safe inductive sensors directly detect the end stop of the high-speed door without contact and without requiring a special counter piece.

Fail-safe inductive sensors

Type	Length [mm]	Enable zone [mm]	Housing material	U _b DC [V]	Protection	Response time in case of a safety request / enable time [ms]	Order no.
	66	10...15 nf	PPE	24	IP 65 / IP 67	≤ 50 / ≤ 200	GM7015

f = flush / nf = non flush


Safety during equipment operation




Protection of hazardous areas against unwanted access

While a rolling installation is in operation some hazardous areas, e.g. areas with rotating equipment parts, must not be accessed. This is avoided by protective screens and door switches with guard locking.

Door switch with guard locking

Type	Description	Order no.
	Safety switch with guard locking · Normally closed principle · Rotatable actuating head made of metal · Mechanical release on the front · Supply via AS-i / solenoid supply ext. from 24 V DC · M12 connector · Housing materials: thermoplastic reinforced glass-fibre	AC9015

Accessories

Type	Description	Order no.
	Actuator S standard straight · With rubber bush, overtravel 5 mm · Suitable for a maximum pull force of 2500 N for the door switches AC9015 - AC9045	E79035


Positioning of the shear stand



Position monitoring on the rotary plate of the shear stands

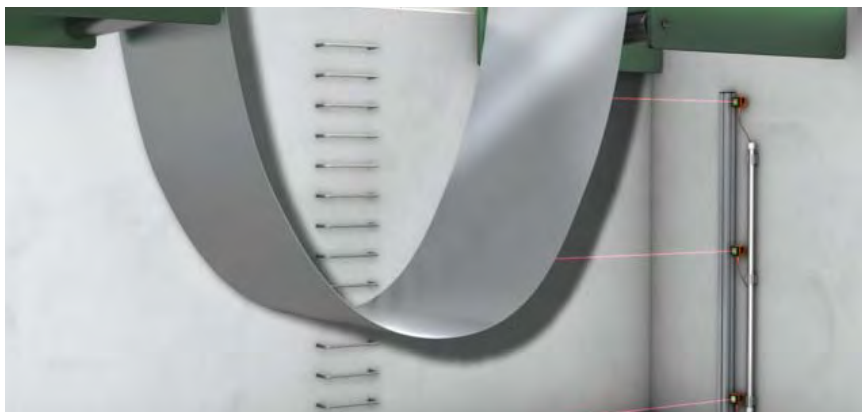
By means of a rotary plate two shear stands are exchanged. To avoid rotation of the plate if a shear stand is not correctly positioned an inductive sensor detects the stand position.

Inductive sensors for positioning equipment parts

Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f [Hz]	I_{load} [mA]	Order no.
	Ø 34 / L = 98	20 nf	PBT	10...36	IP 65	350	250	IB5063

f = flush / nf = non flush


Loop pit



Sag control with PMD time of flight sensors

The O1D PMD sensors monitor the correct running of the steel strip and coil unwinding. Once a defined circumference has been reached, the coil changeover starts automatically.

PMD distance sensors with time of flight measurement

Type	Operating principle	Range	Sampling rate [Hz]	Spot Ø at max. range [mm]	U_b [V]	Order no.
	Photoelectric distance sensor	0.2...10 m	1...50	< 15 x 15	18...30	O1D100

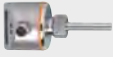
Monitoring of belt centring control



Travel speed limitation of the positioning cylinder

Coils must move straight into the installations. To ensure this the whole coiler is hydraulically moved transversely to the direction of movement. A flow sensor monitors the limitation of the travel speed.

Flow sensors

Type	Setting range liquids / gases [cm/s]	Material sensor tip	Medium temperature [°C]	Pressure rating [bar]	Response time [s]	U _b [V]	Order no.
	3...300 / 200...3000	3...100 / 200...800	-25...80	300	1...2 / 1...10	18...36	SI5010


Cutting straightened sheets to length



Straightened strip is cut to length as needed

After processing the sheets blanks are cut to the dimensions as requested by customers. Encoders ensure that the lengths are precisely measured.

Multiturn encoder for linear measurement

Type	Resolution	U _b [V]	f [kHz]	I _{load} [mA]	Shaft [mm]	Ambient temperature [°C]	Cable entry	Order no.
	4096	4.5...30	–	–	6	-40...85	axial	RM8001


Monitoring a roller conveyor for occupied sections



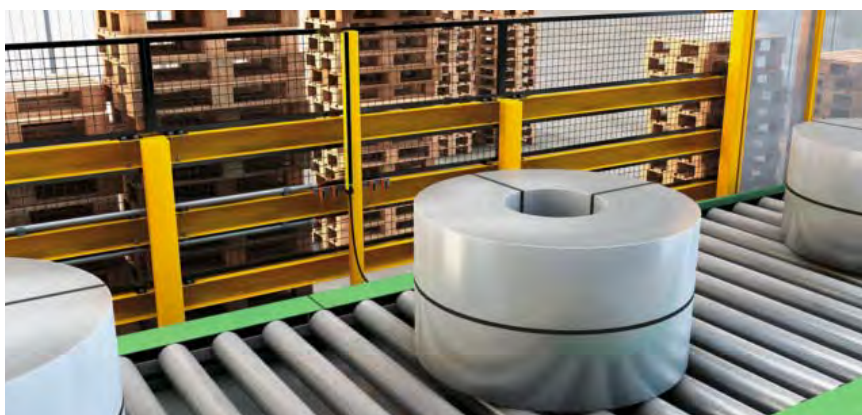
Automation of the conveyors

The roller conveyors are split up into individual sections. To ensure that no coil is moved into a section which is already occupied photoelectric sensors with polarisation filter detect the material on the conveyor.

Photoelectric sensors for conveyor control

Type	Operating principle	Range	Type of light	Spot Ø at max. range [mm]	Output H = light-on D = dark-on	Order no.
	Polarisation filter	0.075...10 m	Red	250	H/D PNP	O5P500


Coil transport




Coil transport on roller conveyors

The O5S (transmitter) / O5E (receiver) through-beam sensors detect the coils on the roller conveyors. This ensures a correct transport to the packaging lines.

Photoelectric sensors for determining position

Type	Operating principle	Range	Type of light	Spot Ø at max. range [mm]	Output H = light-on D = dark-on	Order no.
	Transmitter	25 m	Red	625	–	O5S500
	Receiver	25 m	Red	–	H/D PNP	O5E500

Safety light curtains for access prevention

Type	Sensor length [mm]	Resolution / detection capacity [mm]	Protected area height [mm]	Protected area width [m]	Response time [ms]	U _B [V]	Order no.
	813	90	760	0...4 / 3...12	4.5	24	OY105S


Temporary coil store – packaging line



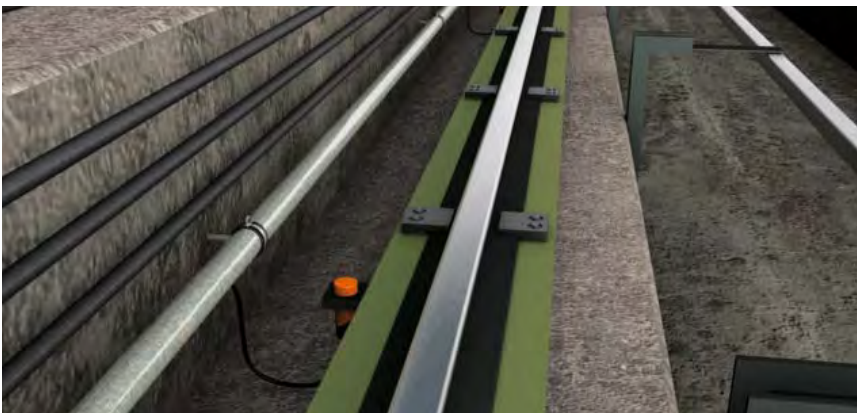
Temporary store for coils from the shears to the packaging line

If it is not possible to directly transport the cut strip from the shears to the packaging line, it is stored temporarily. The OG diffuse reflection sensor precisely detects whether the store is occupied.

Photoelectric sensors for monitoring storage locations

Type	Operating principle	Range	Type of light	Spot Ø at max. range [mm]	Output H = light-on D = dark-on	Order no.
	Background suppression	15...300 mm	Red	25	H/D PNP	OGH500


Temporary coil store – transport cars



Transport car positioning

Coils are transported from the temporary store to the upenders of the packaging lines. For exact positioning inductive sensors with a long sensing range are used.

Inductive sensors for determining position

Type	Dimensions [mm]	Sensing range [mm]	Material	U _b [V]	Protection	f [Hz]	I _{load} [mA]	Order no.
	Ø 34 / L = 98	20 nf	PBT	10...55	IP 65	300	300	IB5124

f = flush / nf = non flush

Coil centring in the packaging line



Centring of coils before packing them on pallets

If coils are dispatched on pallets, they must be positioned in the centre. Centring is done before lifting them from the roller conveyor onto the pallet. An inductive sensor is used to detect the material.

Inductive sensors for detecting the material

Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f [Hz]	I_{load} [mA]	Order no.
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40 x 40 x 54

20 f

PA (polyamide)

10...36

IP 67

100

200

IM5115

f = flush / nf = non flush

Connectors

Type	Description	Order no.
------	-------------	-----------



Socket · angled · Free from silicone · Gold-plated contacts · M12 connector · 5 m ·
Housing materials: housing: PVC orange / sealing: EPDM

EVT004

Detection of material under an electromagnet



Control of the electromagnet

The centred coils are lifted onto the pallets using an electromagnet. The plunger moved by the coil is detected using an inductive sensor. This ensures that material is under the electromagnet.

Inductive sensor for electromagnet monitoring

Type	Dimensions [mm]	Sensing range [mm]	Material	U_b [V]	Protection	f [Hz]	I_{load} [mA]	Order no.
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Ø 34 / L = 82

20 nf

PBT

10...36

IP 67

60

250

IB5096

f = flush / nf = non flush

Algeria

**Sarl AMS Algérie - Automatismes
Motorisation & Services**
Lotissement C, lot n°190 B
Draria - 16000 ALGER
Tel. +213 (0)5 59 43 45 22
Tel. +213 (0) 23 26 41 45
Fax +213 (0)23 26 42 58
contact@amsalgérie.com
www.amsalgerie.com

Argentina

ifm electronic s.r.l.
Lola Mora 421
10° piso, oficina 3
1107 - Puerto Madero
Ciudad Aut. Buenos Aires
Tel./Fax +54 (011) 5353-3436
Interior del país: 0810-345-3436
info.ar@ifm.com
www.ifm.com/ar

Australia

ifm efector pty ltd.
PO Box 479
Suite 3, 745 Springvale Road
Mulgrave VIC 3170
Tel. 1300 365 088
Fax 1300 365 070
sales.au@ifm.com
www.ifm.com/au

Austria

ifm electronic gmbh
Wienerbergstraße 41
Gebäude E
1120 Vienna
Tel. +43 / 1 / 617 45 00
Fax +43 / 1 / 617 45 00 10
info.at@ifm.com
www.ifm.com/at

Bangladesh

Sensotec Automation and Control
5, New Eskaton Road
Ghausnagar, Ramna
Dhaka 1000 Bangladesh
Tel. +880 171 154 689 0
sensotec@agni.com

Belarus

ifm electronic
ELTICON Trade House Ltd.
2A Ostroshitskaya st.
220125 Minsk, Belarus
Tel.: +375-17-286-4649
Fax: +375-17-289-6169
E-mail: info@elticon.ru
www.elticon.ru
MilkGroup LLC.
220015 Minsk, Belarus
Ponomarenko str., 35A, office 517
Tel./Fax: +375 17 207 29 34
E-mail: ifm@milkgroup.by
www.milkgroup.by
FilFar Technology LLC
Zapadnaya str., 13, office 519
220036 Minsk, Belarus
Tel.: +375 (44) 540-40-40
E-mail: zapros@filfar.by
www.filfar-technology.by

Belgium and Luxembourg

ifm electronic n.v./s.a.
Zuiderlaan 91 - B6
1731 Zellik
Tel. +32 2 481 0220
Fax +32 2 463 1795
info.be@ifm.com
www.ifm.com/be

Bolivia

BAVARIA S.R.L.
Álvaro Baptista Vargas
Zona Calacoto Alto, Urb. Morocollo -
Santos Pariamo
C. Mario Diaz de medina (26-A), n° 32
La Paz
Tel. 00-591-2-279 269 1
Mobile 00-591-720-47 442
PoBox N°312248
alvarobaptista@bavaria.bo
www.bavaria.bo

Brazil

ifm electronic Ltda.
Rua Leonora Cintra, 140
Jardim Analia Franco
03337-000 São Paulo
Tel. +55-11-2672-1730
Fax +55-11-2673-3501
info.br@ifm.com
www.ifm.com/br

Bulgaria

ifm electronic eood
1202 Sofia
ul. Klokotnica No 2A
Business Centre IVEL
fl.4, office 17
Tel. +359 2 807 59 69
Fax +359 2 807 59 60
info.bg@ifm.com

Canada

ifm efector Canada Inc.
2233 Argentinia Road, Suite 104
Mississauga, ON L5N 2X7
Tel. 855-436-2262
Fax 855-399-5099
info.ca@ifm.com
www.ifm.com/ca

Chile

ifm electronic SpA
Presidente Eduardo Frei Montalva
6199, Oficina 5032
Comuna de Conchalí
Región Metropolitana
Tel.: +56-2-32239282
info.cl@ifm.com

China

ifm electronic (Shanghai) Co., Ltd
Building 15,
No. 1000, Zhangheng Road,
Pu Dong District.
201203 Shanghai, P.R.China
Tel. +86 21 3813 4800
Fax +86 21 5027 8669
400 880 6651
Involving: Contact quotation, Product
delivery, Technical support, etc
info.cn@ifm.com
www.ifm.com/cn
ifm electronic (HK) Ltd
Unit 2106, 21/F,
Tower 2, Metroplaza
No. 223 Hing Fong Road,
Kwai Chung,
N.T., Hong Kong.
info.hk@ifm.com
www.ifm.com/hk
ifm electronic (Taiwan) Limited
9F.-6, No.12, Fuxing 4th Rd., Cianjhen
District, Kaohsiung City,
Postal Code 806, Taiwan, R.O.C.
Tel. +886-7-335-7778
Fax +886-7-335-6878
info.tw@ifm.com
www.ifm.com/tw

Colombia

SENSOMATIC Y CIA LTDA.
Calle 1 C 25a - 50
Bogotá D.C.
Tel. +57 313 430 2264
Tel. +57 1 407 96 96
info@sensomatic-ltda.com
www.sensomatic-ltda.com

Costa Rica

Gen Bus S.A
Santa Rosa, Sto. Domingo, Heredia.
Bodegas Del Sol, Bodega n° 22
Tel. + (506) 25 60 39 58
Tel. + (506) 22 62 39 27
Fax + (506) 22 62 16 74

Croatia

ifm electronic gmbh
Wienerbergstr. 41
Gebäude E
1120 Wien
Tel. +43 / 1 / 617 45 00
Fax +43 / 1 / 617 45 00 10
info.hr@ifm.com
www.ifm.com/hr

Czech Republic

ifm electronic, spol. s r.o.
U Křížku 571
252 43 Prague
Tel. +420 267 990 211
Fax +420 267 750 180
info.cz@ifm.com
www.ifm.com/cz

Denmark

ifm electronic a/s
Ringager 4A
2605 Brøndby
Tel. +45 70 20 11 08
info.dk@ifm.com
www.ifm.com/dk

Dominican Republic

WECH AUTOCONTROLES S. A.
Ave. Romulo Betancourt 2158
Edificio Wech
Urb. Renacimiento
Santo Domingo
Tel. + 1 809-531-0550
Fax + 1 809-531-9175
wech@verizon.net.do
www.wechautocontroles.com.do

Ecuador

INSELEC CIA. LTDA.
Av. de los Arupos
E1-202 y Pan. Norte- Km 5 ½
Quito
Tel. +593 2 28074- 76 - 78
Fax +593 2 2807475
inselec@inselec.com.ec
www.inselec.com.ec

Egypt

**Egyptian Establishment
for Electromechanical Supplies**
Mr. Ahmed Gouda
27 Al-Salam Street
Al Arezona, Al Haram Road
Giza 12111, Cairo
Tel. +20 / 2 / 586 49 49
Fax +20 / 2 / 586 49 49
Mobile +20 10 10 61 791
ahmed_gouda97@yahoo.com

El Salvador

Provinter
Prolongación Boulevard Constitución,
Residencial la Gloria,
Block C-3 pje. 2-C, N*1 Mejicanos,
San Salvador, El Salvador
Tel. + (503) 25643005
Ventas@provintersv.com

Estonia

Pesmel Estonia LTD
Segu 4
76505 Saue
Tel. +372 674 73 30
Fax +372 674 73 31
pesmel@pesmel.ee
www.pesmel.ee

Finland

ifm electronic oy
Vaakatie 5
00440 Helsinki
Tel. +358 (0)75 329 5000
Fax +358 (0)75 329 5010
info.fi@ifm.com
www.ifm.com/fi

France

ifm electronic
Siège :
Savoie Technolac BP226
73374 Le Bourget du Lac
Agence commerciale :
Immeuble Uranus
1-3 rue Jean Richepin
93192 NOISY LE GRAND CEDEX
Tel. 0820 22 30 01
Fax 0820 22 22 04
info.fr@ifm.com
www.ifm.com/fr

Germany

ifm electronic gmbh
Friedrichstr. 1
45128 Essen
Tel. +49 201 24 22 0
Fax +49 201 24 22 12 00
info@ifm.com
www.ifm.com/de

Greece

ifm electronic monoprosofi E.P.E.
27, Andrea Papandreou Street
15125 Amaroussi
Tel. +30 210 61 800 90
Fax +30 210 61 994 00
info.gr@ifm.com
www.ifm.com/gr

Guatemala

**Ingenieros Civiles Electromecánicos
Asociados, S.A. (IASA)**
20 Calle 25-55 Zona 12
Empresarial El Cortijo III Bodega n° 907,
Guatemala City
Tel. +502-23061300
info@iasa.com.gt

Honduras

R y D INDUSTRIAL
Bo. Paz Barahona
11 Ave. 14 y 15 Calle
S.O. #142
San Pedro Sula
Tel. +(504) 2550-3703
Tel. +(504) 2558-9313
ventas@rydindustrial.com

Hungary

ifm electronic kft.
Szent Imre út 59. I.em.
H-9028 Győr
Tel. +36-96 / 518-397
Fax +36-96 / 518-398
info.hu@ifm.com
www.ifm.com/hu

India

ifm electronic India Private Limited
Plot No. P-39/1
MIDC Gokul Shirgaon
Kolhapur – 416234
Maharashtra State
Tel. +91 / 231 / 267 27 70
Fax +91 / 231 / 267 23 88
info@ifm-electronic.in
www.ifm.com/in

Indonesia

PT Indoserako Sejahtera
Jl. P. Jayakarta 121 No. 59
10730 Jakarta Pusat
Tel. +62 / 21 6 24 8923
Fax +62 / 21 6 24 8922
harry@indoserako.com

Ireland

ifm electronic (Ireland) Ltd.
No. 7, The Courtyard
Kilcarbery Business Park
New Nangor Road
Clondalkin
Dublin 22
Tel. +353 / 1 / 461 32 00
Fax +353 / 1 / 457 38 28
sales_ie@ifm.com
www.ifm.com/ie

Israel

Astragal Ltd.
3, Hashikma Str.
Azur 58001
P.O. Box 99
Azur 58190
Tel. +972 / 3 / 5 59 16 60
Fax +972 / 3 / 5 59 23 40
astragal@astragal.co.il
www.astragal.co.il

Italy

ifm electronic
Centro Direzionale Colleoni
Palazzo Andromeda 2
Via Paracelso n. 18
20864 Agrate Brianza (MB)
Tel. +39 (0)39-6899982
Fax +39 (0)39-6899995
info.it@ifm.com
www.ifm.com/it

Japan

efector co. ltd.
18F WBG Marive-west
2-6-1 Nakase, Mihama-ku
Chiba-shi, Chiba 261-7118
info.jp@ifm.com
www.ifm.com/jp

Jordan

Al Mashreqan Trading Supplies
P.O.Box.851054
11185 Swaifieh
Amman
Tel. +962 6 581 8841
Fax +962 6 581 8892
info@mashreqan.com

Korea

ifm electronic Ltd.
Hyundai Liberty House 201
Dokseodang-ro Yongsan-Gu
04420 Seoul
Tel. +82 2-790-5610
Fax +82 2-790-5613
info.kr@ifm.com
www.ifm.com/kr

Kuwait

Kana Controls
2nd Floor Khalid Fauzan Building
Building No. 1670
Street No. 7, Block No. 1
Al-Rai Industrial Area,
P.O. Box - 25593,
13116 Safat
Tel. +965-24741537
Fax +965-24741537
info@kanacontrols.com
www.kanacontrols.com

Latvia

EC Systems
Katlakalna Str. 4A
1073 Riga
Tel. +371 724 1231
Fax +371 724 8478
alnis@ecsystems.lv
www.ecsystems.lv

Lebanon

**Middle East Development Co. SAL
(MEDEVCO)**
Medevco Building
Jeita Main Road
Jeita - Kesrouan, Lebanon
Mail address :
P.O.Box 67
Jounieh
Lebanon
Tel. +961-9-233550
Fax +961-9-233554
info@medevco-lebanon.com

Lithuania

Elinta UAB
Terminalo g. 3, Biruliškių k.,
Karmėlavos sen.
LT-54469 Kauno raj. (Kauno LEZ)
Tel. +370 37 351 999
Fax +370 37 452 780
sales@elinta.lt
www.elintosprekyba.lt

Malaysia & Singapore

ifm electronic Pte. Ltd
Malaysian Branch Office
No. 9F – 2A, 9th Floor,
Tower 4 @ PFCC, Jalan Puteri 1/2,
Bandar Puteri Puchong,
47100 Puchong, Selangor
Tel. + 603 8066 9853
Fax + 603 8066 9854
sales.my@ifm.com
www.ifm.com/my
Singapore Branch Office
25, International Business Park
#03-26/29 German Center
609916 Singapore
Tel. +6565628661
Fax +6565628660
sales.sg@ifm.com
www.ifm.com/sg

Mexico

ifm efector S. de R.L. de C.V.
Ave. Arq. Pedro Ramirez Vázquez 200-4
Planta Baja, Col. Valle Oriente.
San Pedro Garza Garcia, N.L. 66269
Tel. +52-81-8040-3535
Fax +52-81-8040-2343
clientes.mx@ifm.com
www.ifm.com/mx

Morocco

SOFIMED
137, Boulevard Moulay Ismail -
Roches Noires
20290 - Casablanca
Tel. +212 522 240 101
Fax +212 522 240 100
www.sofimed.ma

Namibia

ifm electronic (pty) Ltd
1 Basement Office,
Decor House
25 Dr. W. Kulz Street
Windhoek
Namibia
Tel. +264 61 300984 / 300998
Fax +264 61 300910
Fax to email +264 88 651 9943
info.na@ifm.com
www.ifm.com/na

Netherlands

ifm electronic b.v.
Deventerweg 1 E
3843 GA Harderwijk
Tel. +31 / 341 438 438
Fax +31 / 341 438 430
info.nl@ifm.com
www.ifm.com/nl

New Zealand

ifm efector pty ltd.
Unit 13, 930 Great South Road
Penrose, Auckland
Tel. +64 / 95 79 69 91
Fax +64 / 95 79 92 82
sales.nz@ifm.com
www.ifm.com/nz

Nigeria

Automated Process Ltd
3rd Floor, 32 Lagos Abeokuta
Expressway
Near Cement Bus Stop
Dopemu, Agege
Lagos State
Tel. + 234 / 01 / 4729 967
Fax + 234 / 01 / 4925 865
sales@automated-process.com
www.automated-process.com

Norway

Siv.Ing. J.F.Knudtzen AS
Billingstadsletta 97
1396 Billingstad
Postboks 160
1378 Nesbru
Tel. +47 / 66 98 33 50
Fax +47 / 66 98 09 55
firmapost@jfknudtzen.no
www.jfknudtzen.no

Oman

Technical Engineering Company LLC.
P.O. Box 59
Madinat Al Sultan Qaboos
Postal Code 115
Tel. +968 24503593
Fax +968 24503573
tecoman@omantel.net.om

Panama

JDA Ingeniería
Dirección: Edificio Diamante 3, 3A,
Villa De Las Fuentes 1.
Ciudad de Panamá.
Tel: (507) 399-8200/ 6200-4205
jaguilar@daingenieria.com
www.jdaingenieria.com

Peru

dekatec s.a.c.
Los Calderos 188
Urb. Vulcano, Ate
Lima
Tel. +511 / 348 0293
Tel. +511 / 348 0458
Tel. +511 / 348 2269
Fax +511 / 349 0110
dkleffmann@dekatec.com.pe
www.dekatec.com.pe

Philippines

Gram Industrial, Inc.
Bldg. 9 Don Mariano Lim
Industrial Complex,
Alabang Zapote Road
corner Concha Cruz Drive,
Brgy. Almanza 1 Las Piñas City
Tel. 632-8502218 / 8508496
Fax 632-8077173 / 8503055
bongalido@gram.com.ph

Poland

ifm electronic Sp.z o.o.
ul. Weglowa 7
PL 40-105 Katowice
Tel. +48 32 70 56 454
Tel. +48 32 70 56 480
Fax +48 32 70 56 455
info.pl@ifm.com
www.ifm.com/pl

Portugal

ifm electronic s.a.
Parque Tecnológico S. Félix da Marinha
Avenida Manuel Violas, 476
4410-137 São Félix da Marinha
Tel. +351 22 37 17 108
Fax +351 22 37 17 110
info.pt@ifm.com
www.ifm.com/pt

Qatar

Advanced Fluid Power L.L.C
P.O. Box 201382
Barwa Village Al Wakra
Building No 1
Doha-Qatar
Tel. +974-40164275
Fax +974-40164274
sales@afp-qatar.com
www.afp-qatar.com

Romania

ifm electronic s.r.l.
Mihai Viteazu Str. Nr. 1
Selimbar, Sibiu
557260
Tel. 0040 269 224550
Fax 0040 269 224766
info.ro@ifm.com

Russia

ifm electronic
Ibragimova, 31, k.50
office 808
105318 Moscow
Tel. +7 (495) 921-44-14
P.O. 0040 269 224550
Fax +7 (495) 651-82-97
info.ru@ifm.com
www.ifm.com/ru

Saudi Arabia

**Noor Al-Shomoe
for Electric & Maintenance**
King Khalid Street, Cross 5
P.O. Box 2571
Al-Khobar 31952
Kingdom of Saudi Arabia
Tel. +9 663 864 49 58
Fax +9 663 894 63 41
h.o.info@nooralshomoe.com

**Bariq Al Emdadat
Trading Establishment**
P.O. Box 27001, Riyadh 11653
Kingdom of Saudi Arabia
Contact: Abdul Aziz Mohamed Elias
Tel. +966 11 4728782
Fax +966 11 4725576
Mobile 00966 53 2626686
azizelias@bariqarabia.com

Singapore

ifm electronic Pte. Ltd.
25, International Business Park
#03-26/29 German Center
609916 Singapore
Tel. +6565628661
Fax +6565628660
sales.sg@ifm.com
www.ifm.com/sg

Slovakia

ifm electronic spol. s.r.o.
Rybnicna 40
831 06 Bratislava
Tel. +421 / 2 / 44 87 23 29
Fax +421 / 2 / 44 64 60 42
info.sk@ifm.com
www.ifm.com/sk

South Africa

ifm electronic (pty) Ltd
112 Sovereign Drive,
Route 21 Corporate Park
Centurion
0157
Postnet Suite 279
Postnet Bag X8
Elardus Park
0047
National: 0861 IFM RSA (436 772)
International: +72 12 450 0400
Fax: +27 12 450 0412
info.za@ifm.com
www.ifm.com/za

Spain

ifm electronic s.l.
Parc Mas Blau
Edificio Inbisa
c/ Garrotxa 6-8
08820 El Prat de Llobregat
Tel. 0034 93 479 30 80
Fax 0034 93 479 30 86
info.es@ifm.com
www.ifm.com/es

Sri Lanka

Isaro Automation Systems Ltd.
First Floor,
400 Galle Road,Rawathawatta.
Moratuwa
Tel. +94 114 216 784
Fax + 94 11 2644 224
isaro@slt.net.lk

Sweden

ifm electronic ab
Drakegatan 6
41250 Gothenburg
Tel. växel 031-750 23 00
Fax 031-750 23 29
info.se@ifm.com
www.ifm.com/se

Switzerland

ifm electronic ag
Altgraben 27
4624 Härkingen
Tel. 0800 88 80 33
Fax 0800 88 80 39
info.ch@ifm.com
www.ifm.com/ch

Thailand

SCM ALLIANZE CO., LTD.
700/19-24
Phaholyothin Road
Samsennai Phayatai
Bangkok 10400
Tel. +66 02 615 4888
contact@scma.co.th
www.scmallianze.com

Tunesia

TECHNOPREST
GP1 – Km 5,5 Rte de Sousse –
Z.I 2013 Ben Arous
Tel. +216 71 389 203
Fax + 216 71 389 215
technoprest@technoprest.com.tn

Turkey

**ifm electronic Elektrikli
ve Elektronik Aletler
İth.İhr.Paz.Tic.Ltd.Şti.**
Merkez Mah. Nadide Sok.
Anittepe Sitesi No:28
34381 Şişli / İstanbul
Tel. +90 / 212 / 210 5080
Fax +90 / 212 / 221 7159
info.tr@ifm.com
www.ifm.com/tr

Ukraine

ifm electronic
Marilyn Raskovoj 11
02660 Kiev
Tel. +380 44 501 8543
Fax +380 44 501 8543
info.ua@ifm.com
www.ifm.com/ua

United Arab Emirates

Al Injazat Technical Services Est.
P.O. Box 42895
Al Qubaisi bldg floor 0 flat # 4
Liwa street corner of corniche road,
Abu Dhabi
Tel. +971-2-6585400
Fax +971-2-6585401
Mobil +971-50-6811072
kamran@injazat.ae
www.injazat.ae

United Kingdom

ifm electronic Ltd.
efector House
Kingsway Business Park
Oldfield Road
Hampton
Middlesex TW12 2HD
Tel. +44 / 20 / 8213 0000
Fax +44 / 20 / 8213 0001
enquiry_gb@ifm.com
www.ifm.com/uk

USA

ifm efector, inc.
1100 Atwater Dr.
Malvern, PA 19355
Tel. +1-800-441-8246
Fax +1-800-329-0436
info.us@ifm.com
www.ifm.com/us

Venezuela

Petrobornas, C.A.
C.C. Plaza Aeropuerto,
Galería piso 1, Local P1-B03,
Calle Neverí, Unare,
Puerto Ordaz 8050,
Estado Bolívar
Tel. + 58 286 9513382
info@petrobornas.net
www.petrobornas.net

Vietnam

**The Representative Office
of ifm electronic gmbh
in Ho Chi Minh City**
7A-7th Floor,
#467 Dien Bien Phu Street,
Ward 25, Binh Thanh District,
Ho Chi Minh City 700000
Tel. +84-8-35125177
Fax +84-8-35125178
sales.vn@ifm.com



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ifm electronic gmbh
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45128 Essen
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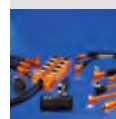
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