

# Application Highlight:

## Replacement of TI560/565 with CTI 2500-C300 on Heidelberg-Harris M1000B Web Printing Press

In Wells, Maine, USA, Spencer Press produces a variety of products including catalogs, press-pasted booklets, free-standing inserts and self-mailers. The company was acquired by RR Donnelley in 2005.

Due to continued issues with maintaining the TI 560/565-based control system on its M1000 press, the company in 2007 contacted Goss International, who acquired Heidelberg's web press and high-volume postpress business in August of 2004. Goss, in turn, contacted CTI regarding the use of our new 2500 Series™ processor in replacement of the 565.



Figure 1 M1000B Printing Press

### Existing Control System Design

The existing control system used on the M1000 press employed a TI560/565 processor with remote I/O connection over coax to thirteen Series 500 I/O bases. Spencer felt that they could continue to maintain the Series 500 I/O systems for a while longer, but wanted an immediate replacement of the controller and upgrade of the programming software to PLC Workshop.

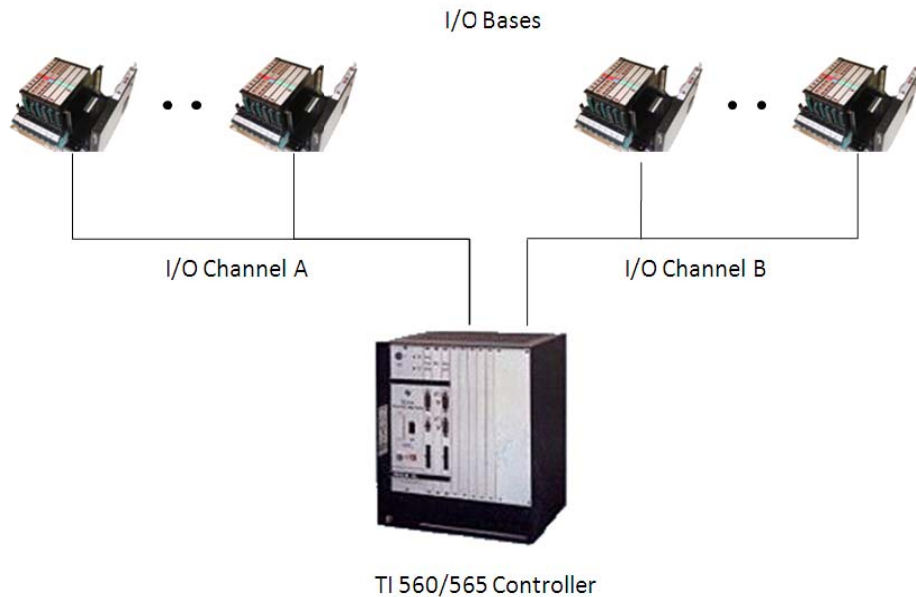


Figure 2 Existing Control System

## Proposed Control System Upgrade

Working together, CTI and Goss application engineers specified a CTI 2500-C300 processor, four slot base, CTI 2512 power supply, and 505-6860 RF I/O channel converter to drive the coaxial I/O network. Because the 2500 Series™ system supports the same instruction set as the one used in the 560/565, no changes in the program logic were required.

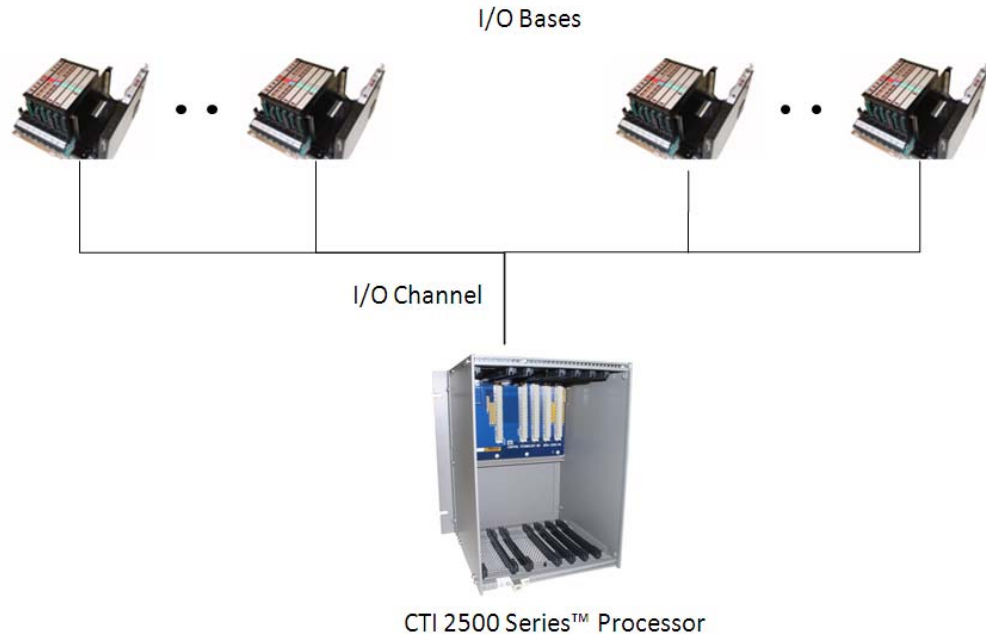


Figure 3 Proposed Control System



## Upgrade Result

The system was initially installed in September 2007. The only program change required was re-addressing of some I/O due to combining the two previous I/O networks into a single network.

After resolving some issues over coax I/O reliability and Series 500 I/O login, the press has been running without incident. RR Donnelley is currently considering the next upgrade phase which includes changeout of the Series 500 I/O bases for new CTI 2500 Series™ systems.



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