

## ELAY30x5 Smart Tool | P/N: 81401338

Featuring Variable Field Output (VFO) technology, this heavy lifter designed for crane use can be controlled using CANopen protocols to de-stack and pick single or multiple sheets. Adjustability of magnetic strength between 0 and 100% allows use of this magnet on parts of varying sizes and material type. CANopen communication allows integration of multiple tools on the same CANopen bus, controlled simultaneously.

NOTE: Base tool does not ship with 88001111 EOAT bracket (transparent at right)

### Specifications

Maximum Breakaway Force <sup>1,2</sup>	2186.9 N
Thickness for De-Stack <sup>3</sup>	0.016" / 0.4mm
Nominal Supply Voltage	24 V DC
Peak Power Draw	2.5 A DC @ 24 V DC
Net Weight	12.6 lb / 5.7 kg
Connector Type	Male M12x1.0 – 5 Pin – A-coded
Mounting Options	6-M6-M6-6 (Both Sides)
Magnetic Pole Footprint	7.33" x 1.6" / 186.2 x 41 mm



Material Thickness - mm (in)	0.6 (.024)	1.0 (.039)	1.5 (.059)	2.0 (.079)	3.0 (.118)	4.0 (.157)	5.0 (.197)	6.0 (.236)	7.0 (.276)	9.5 (.374)	50.0 (1.97)
Maximum Force <sup>1,2,4,5</sup> - Newtons (N)	263.8	536.4	654.1	862.0	1016.0	1274.9	1646.5	1803.4	2002.5	2185.9	2186.9

$$SWL \text{ (Safe Working Load)} = \frac{\text{Maximum Force}^5}{\text{Safety Factor} (\geq 3)}$$

<sup>1</sup> Determined in laboratory environment on SAE1018 Steel with surface roughness 63 micro inches with optimized pole shoes. Many factors contribute to the actual breakaway force and safe working load in each application. Consult a Magswitch Applications Engineer and test the Magswitch in each application before deployment.

<sup>2</sup> All data applies to unit with standard pole shoes installed.

<sup>3</sup> Determined with SAE1018 Steel L=200mm W=200mm.

<sup>4</sup> Values may vary by +/- 5%.

<sup>5</sup> Maximum forces listed above are not safe lifting forces. Designer must take into account safety factor when specifying tool. Magswitch recommends SWL = 3:1 for most lifting applications.



**MAGSWITCH ELAY30x5**

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+ 1(303) 468.0662

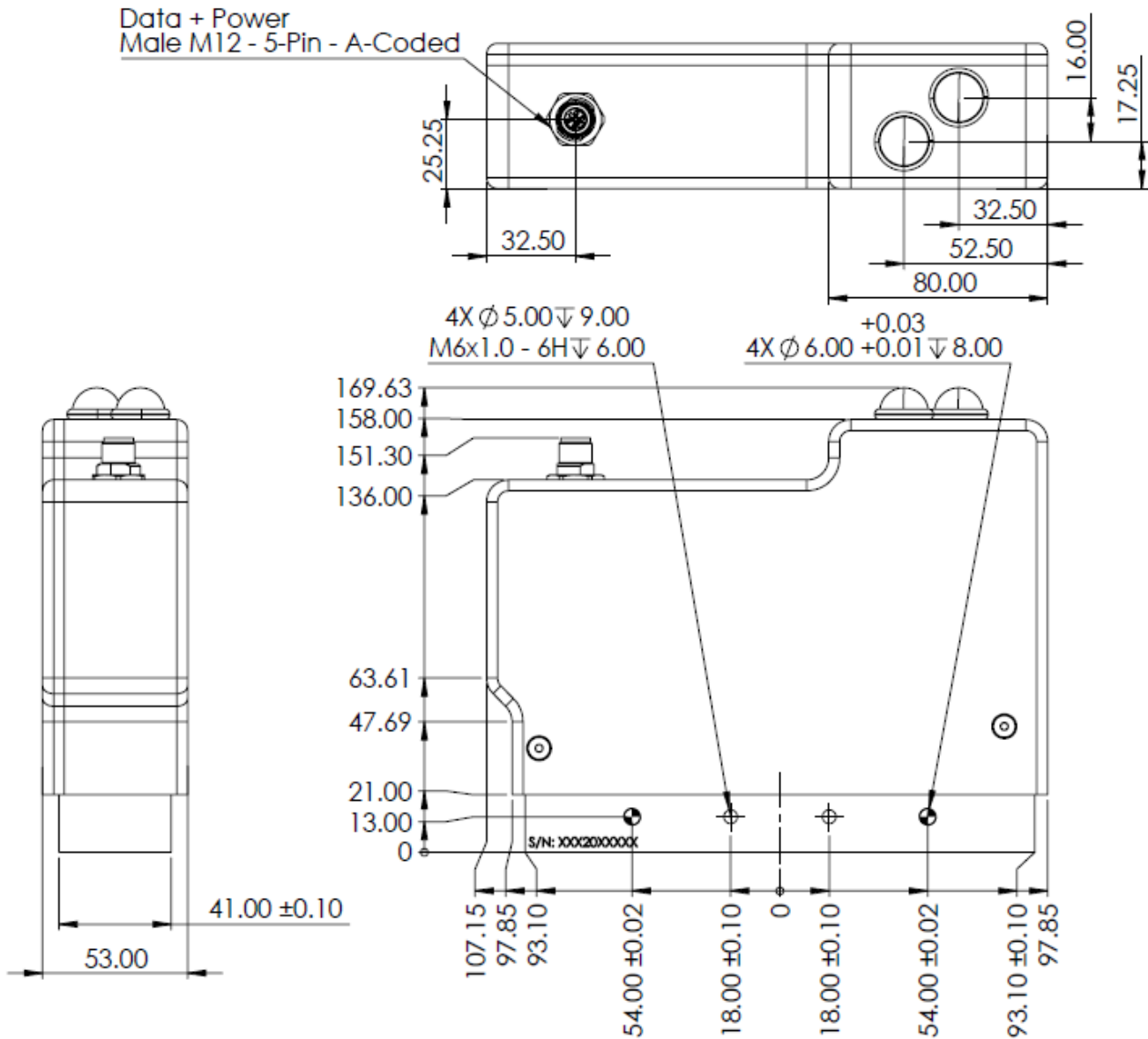
magswitch.com

**Pole shoes required for operation**

**Standard Kits Available:**

88001110	ELAY30x5 Standard Pole Shoe Kit
8800968	ELAY30x5 Thin Target Pole Shoe Kit
88001111	ELAY30x5 Standard EOAT Bracket

**WARNING!**  
Do Not Operate Unless In Contact With  
Ferrous Target!



Pole Shoes Sold Separately



## General Electrical Characteristics

Parameter	Value
Input Voltage Range	24 ± 5% V DC
Inrush Current (70 ms duration)	3 A Max
Rated Current Draw (Peak)	2.5 A DC @ 24 V DC
Rated Current Draw (Continuous)	1 A DC @ 24 V DC
Connector on Tool	Male M12 – 5 Pin – A-Coded

## Ambient Conditions

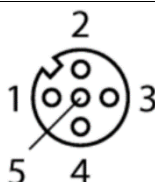
Parameter	Range
Ambient Temperature (Operation)	-10 to +40 Degrees Celsius
Ambient Temperature (Storage)	-25 to +80 Degrees Celsius
Relative Humidity (non-condensing)	0 to 95%

## LED Color Codes

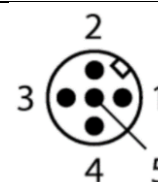
Function/State	Blue LED State	Green LED State
No power to tool	OFF	OFF
Waiting to home magnet	Blinking	Blinking
Magnet actuated OFF	ON	OFF
Magnet actuated ON 100% (Fail-Safe)	ON	ON
Magnet partially actuated	ON	Blinking
Standard calibration routine	Blinks when calibration mode is entered Blinks when steps 1-4 are confirmed	OFF/ON depending on magnet state
Auto-calibration routine	Blinks on entry and exit/confirmation	OFF/ON depending on magnet state

## Connector Pinout

Pin #	Function	Logic
1	Signal Shield	-
2	Vin (V+)	+24 VDC
3	GND (V-)	GND
4	CANopen bus high	TX/RX high line (D1) (CAN H)
5	CANopen bus low	TX/RX low line (D0) (CAN L)



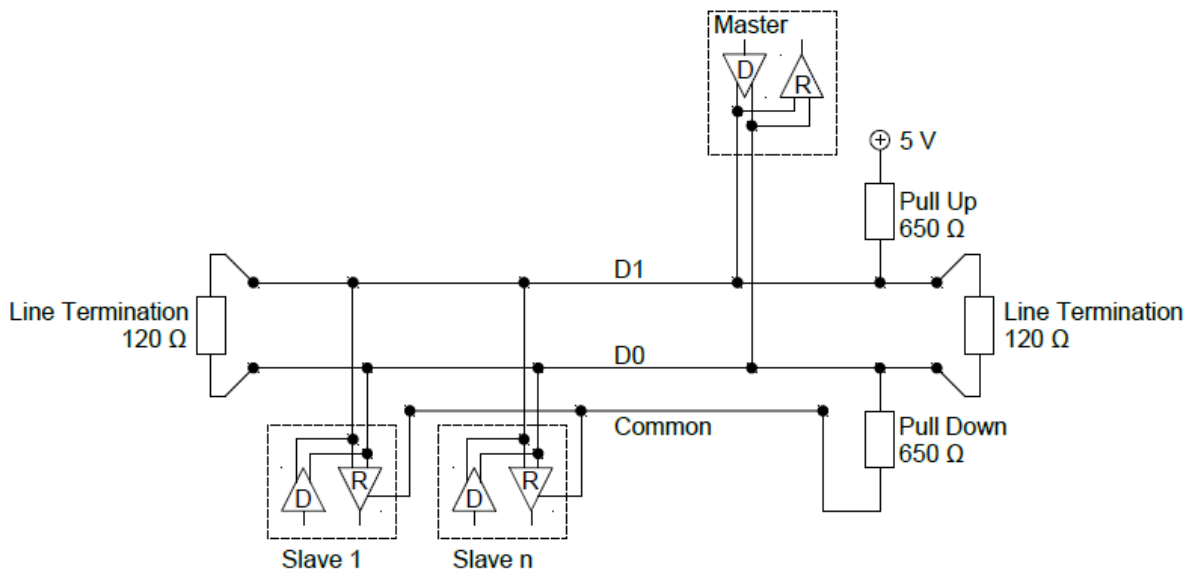
Cable Side: Pin Assignment M12, 5-pin, A-coded, Female Connector (socket-side) View



Tool side: Pin Assignment M12, 5-pin, A-coded, Male Connector (pin-side) View

## CANopen Configuration Information

CAN Baud Rate	250 kBaud, configurable
Default CAN Node ID	$127_d = 7F_h$ , configurable
Device Terminating Resistor	120 $\Omega$ <b>NOT</b> enabled Bus must have 120 $\Omega$ termination resistor installed
Master Device Termination	Master device must have line polarization/termination <b>OR</b> : Apply 450-650 $\Omega$ pull-up to +5V on high line (D1) (CAN_H) Apply 450-650 $\Omega$ pull-down to GND on low line (D0) (CAN_L)



### Changing CANopen NodeID

1. Check object  $2009_h$  for current CANopen NodeID.
  - a. Default NodeID =  $127_d = 7F_h$
2. Write desired NodeID value to  $2009_h$ .
  - a. Acceptable NodeID value range =  $1_d-127_d$
3. To save, write to object  $1010_h$  sub-index  $02_h$  the value  $1702257011_d$  ( $65766173_h$ ).
4. Wait until object  $1010_h$  sub-index  $02_h$  is equal to 1.
5. Disconnect and reconnect power.
6. The device NodeID will now be changed.

### Changing CANopen Baud Rate

Please consult integration/assembly manual 1101334 for instructions on changing the CANopen baud rate. Available baud rates are 10, 20, 50, 125, 250, 500, and 1000 kBaud.

**CANopen I/O Service Data Objects (SDO's) and Functionality**

Type	Object (hex)	Sub Index (hex)	Short Name	Description
Inputs	2400	01	Move Enable	1 = home magnet 2 = move to position set in 2400:02 <b>0 = reset trigger after each move</b>
	2400	02	Set Position	Position 0-100% (increments of 1)
	2400	03	Calibration Trigger	Standard Calibration: 1 = trigger (must be reset to 0 after each trigger in standard calibration) Auto Calibration: 1 = start (with Calibration Mode already set to 1) 999 = exit & don't save <b>0 = reset trigger after setting 1 or 999</b>
	2400	04	Calibration Select	Select calibration storage options 0-3 (4 possible calibrations)
	2400	05	Sensitivity	default = 0 more sensitive = -x less sensitive = x typical x values = 5, 10, 20
	2400	06	Calibration Mode	0 = standard calibration procedure (good for bin picking, etc) 1 = auto calibrate
Outputs	2500	01	Magnet Position	0-100% (<=2 is considered 0)
	2500	02	Magnet State	0 = OFF 1 = Partial ON 2 = Magnet ON 100% (Fail-Safe)
	2500	03	Calibration State	0 = no South Pole, no North Pole, and no part present in range 1 = only North pole on 2 = only South Pole on 3 = both poles on, but no part present 4 = North, South, part present all within Range
	2500	04	In Calibration	0 = not in Calibration 1 = In Standard Calibration 2 = In Auto Calibration
	2500	05	Calibration Step	0 = not in calibration 1 = waiting for best circuit 2 = waiting for worst circuit 3 = waiting for South Pole 4 = waiting for North pole
	2500	06	Cycle Count	Number of times the tool has been turned on to full power
	2500	07	Home Status	0 = not properly homed 1 = Properly homed
	2500	08	Move Status	0 = not complete 1 = Last set move complete
	2500	09	Serial Number	Magswitch Tool Serial Number
	2500	0A	Magnet Software Version	Magswitch Software Version
	2500	0B	Tool Type	30 for E30, 50 for E50
	2005		CANopen Baud Rate	84 <sub>h</sub> = 132 <sub>d</sub> = 125 kBaud by default. Consult configuration manual 1101334 before changing
	2009		CANopen Node ID	0-127 are permissible node IDs 7F <sub>h</sub> = 127 <sub>d</sub> by default

## 2-Step Calibration Procedure

See setup manual 1101334 for more E-series detail.

### Step 1

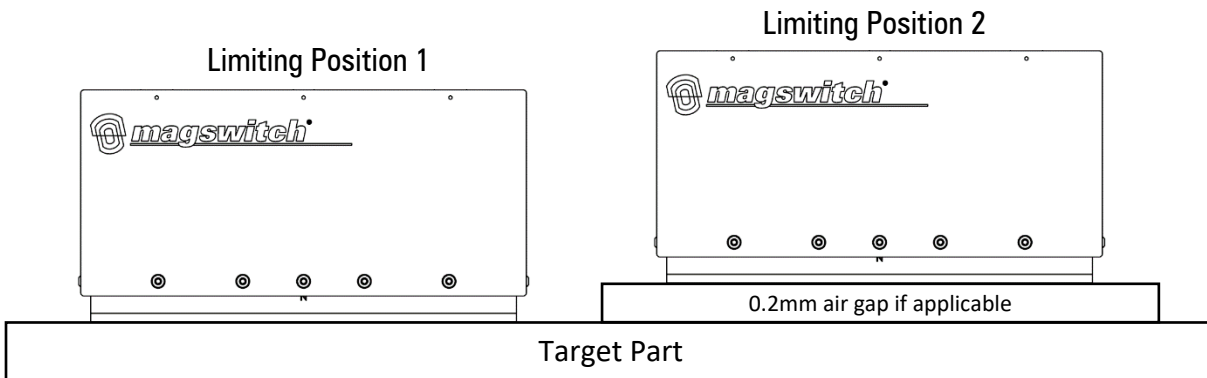
Limiting Position 1 for Calibration Match Signal

### Step 2

Limiting Position 2 for Calibration Match Signal

Object **CalState (2500:03<sub>h</sub>)** will return 4 when the contact quality between both poles and the part lie within the zone created by bounding Limiting Position 1, Limiting Position 2, and North and South Pole calibration signals.

**NOTE:** North and South pole calibration steps 3 and 4 typical of the E30 and E50 tools are removed from the ELAY calibration procedures. This is because the north and south poles of an ELAY tool are elongated, and in most customer applications it is difficult to position the long edge of the magnet near the edge of the part without also impacting the calibration of the opposite pole.



The following flowchart shows the proper CANopen signaling required to enter and set calibrations 0-4. Note that all “output” objects can be polled at any time to determine the current state of the calibration process.

It is critical that the magnet be fully actuated ( $\text{setPosition} / \text{OutPos} = 100$ ) at each calibration step to guarantee proper field values are stored. **The tool will not allow you to confirm calibration steps 1 and 2 unless the magnet is ON and the green light is lit.**

The supplementary document 1101340 can be provided by Magswitch if additional information regarding calibration procedure is needed.

## Auto-Calibration Procedure

Actuate tool OFF and enter auto-calibration mode by setting object  $2400:04 = 1_d$  and then writing  $2400:03 = 1_d$ . Position the tool on the desired part. Once the tool is actuated ON and the green light is lit, the tool records magnetic field strengths in the current configuration and stores them as allowable Part Present boundaries. Add or adjust parts and fixtures to widen the allowable range of field strengths. By writing  $2400:03 = 0_d$ , auto-calibration parameters are saved and standard operation resumes. Tool should NOT be actuated OFF until auto-calibration is exited and saved otherwise calibration values will be skewed. Tool should not be actuated off-target or calibration range will exceed practical usage and part present functionality will be inaccurate.

## E-Series Operational Flowchart

