

90mm Z Profile Modifications

Modification necessary to allow 90mm tall profile Z sections to be handles by Stuga Machines Liniar LCW9022

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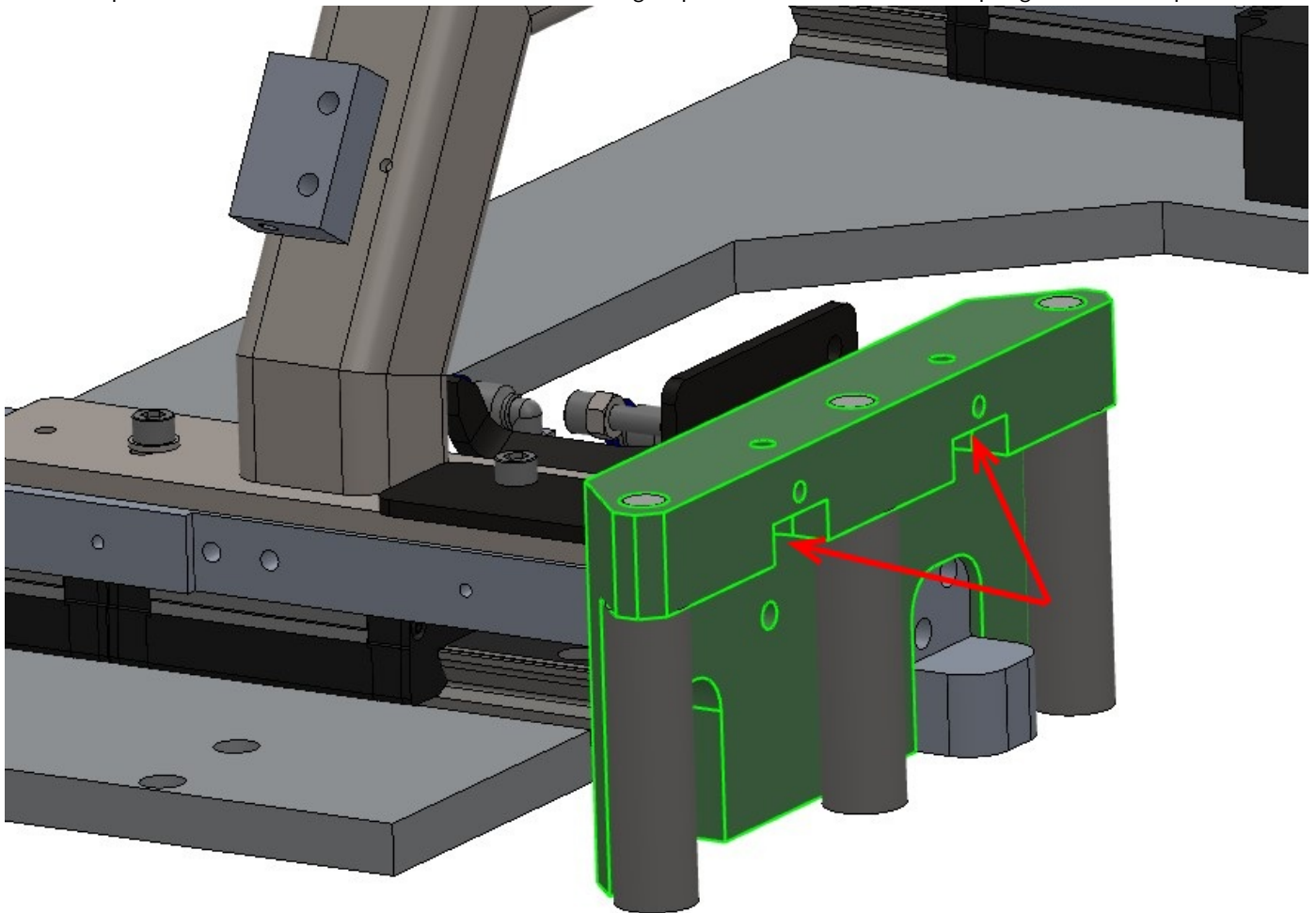
Sawing Clamps - ZX5

Spindle Plunge Bracket Interference

Comments

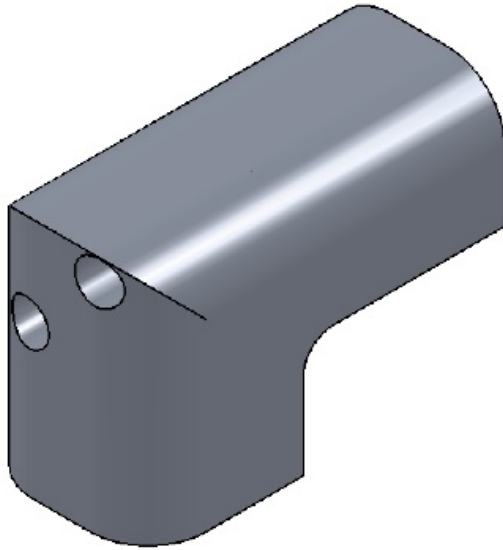
Sawing Clamps - ZX5

The side clamp block D0015174 are modified to allow a roller at a higher position to coincide with the top edge of the 90mm profile



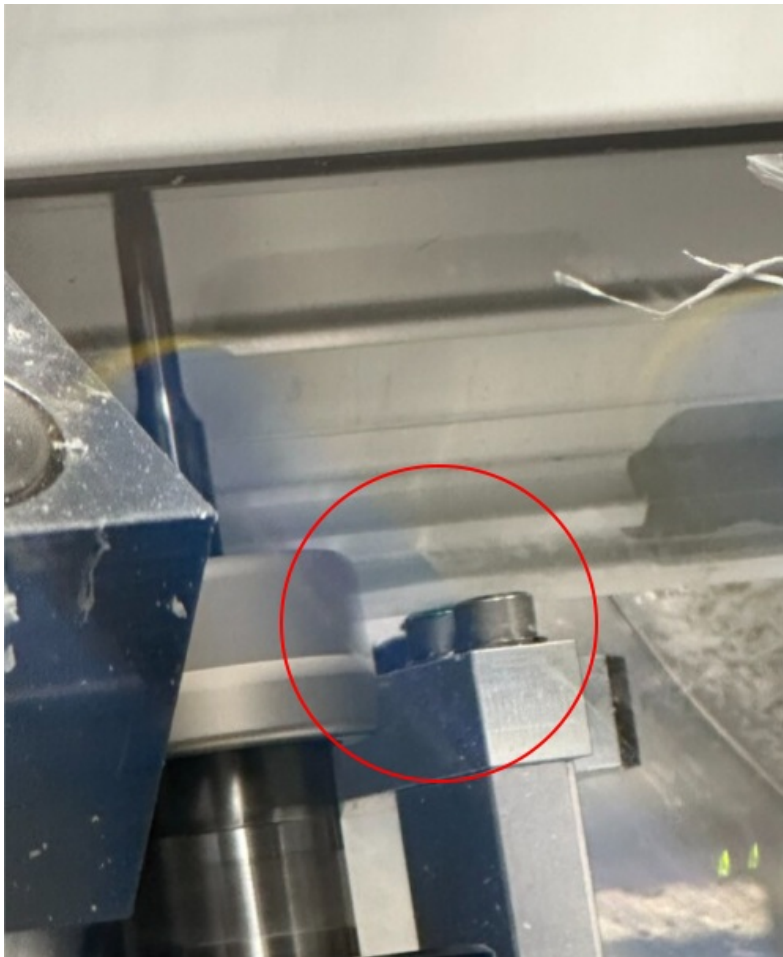
This is a permanent change to this block, and the additional rollers can be fitted as an optional extra - kit is R0019222

A larger Z block D0015178B is also added to this kit to prevent potential pivot points on the taller Z section.



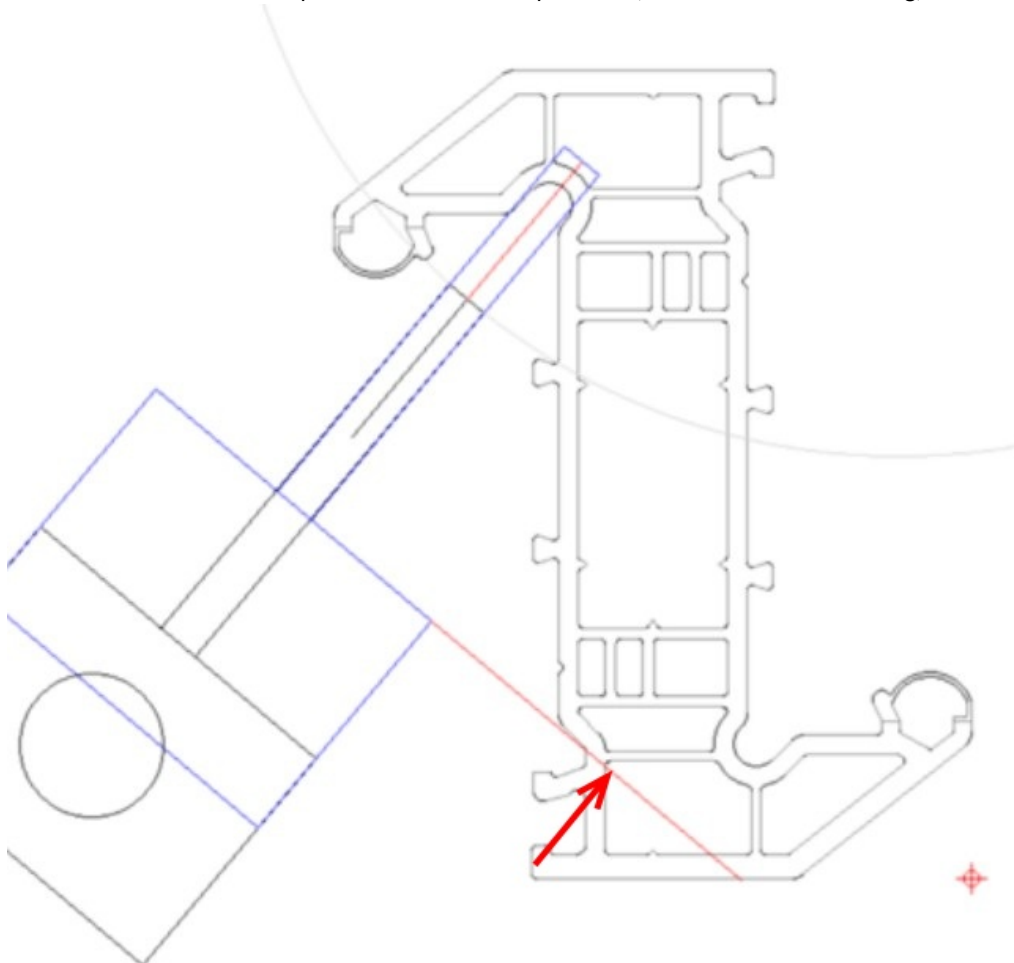
Spindle Plunge Bracket Interference

During testing the DFR operation could not complete the plunge because the spindle plunge bracket interferes with the bottom edge of the profile





There is no way around this issue with the tool depth set at the standard positions (level with inside of the ring)



Solution:

1. Increase the plunge length of a specific tool
2. Create a special drainage operation for DFR on LCW9022
3. Create a variable for the flowops editor to allow a tool depth offset on screen when this tool is selected

i ...A special tool number of 9 is used in this instance so it does not affect the programming depth of all other 5mm drainage tools