Autoflow Loading Offset Parameters

Definition of the parameters for setting the loading arm to the correct position

Contents

Overview

On Autoflow machines, the following parameters are used to correctly set the infeed table position, arm length and stop positions. In all calcualtions, the zero datum point is the centreline of the spindles.

Parameter	Description	Common Values		
		Mk1	Mk2/3	Mk4
loadOffsetX	Distance the gripper has to move after measuring finished to clear the grip finger. This is nominally the dstance from the point of the gripper to the measuring sensor On Mk4 (Sturtz Infeed), if the value is too big, the forward roller clamp may miss end of profile	1680	1680	1580
stopCylinderToZeroX	Distance from zero to the stop cylinder	670	630	580
infeedToZeroX	Distance from Zero to the material side of the loading fence	305	305	590
measureStartPosX	Position to start measuring from This position must place the measuring sensors on the arm to a sensible location On Mk1-3 machines, the start position begins on the material itself	-945	-895	-862

Mk1 Autoflow

Mk2-3 Autoflow

Mk4 Autoflow