

Bug Fix - Centralise Switching Off Prematurely at End of Bar

Solution for issue with centralised bar at end - Centralise clamps coming off too early

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Problem

Centralise clamps come off before the final piece has ejected properly. Sometimes the Eject clamp occasionally misses profile causing it to be ejected dangerously and has can break a cylinder or ruin the chip probe deflectors.

The Blue push eject bar ejects the bar at this point, but because the centraliser has retracted before pushing the bar out of the saw housing, it pivots out as the end of the bar is still in the saw housing.

Solution

Software update that keeps the clamps on during the eject cycle - back end v 6.3012

Also need to change the clamp "Grip" position parameter to -1 (default setting is 30) so the gripper position on its own never forces the clamp to switch off.