



# Commissioning - Off-Cut Laser Sensor

Setting up the laser sensors on the infeed of a Flowline, ZX4 and ZX5.

 Difficulty Easy

 Duration 20 minute(s)

## Contents

Introduction

Video overview

Step 1 - Adjust the "Light Dark"

Step 2 - Adjust Sensitivity

Step 3 - Sensor Height Warning

Step 4 - Input Laser Measurements

Comments

## Introduction

Infeed Off-Cut Laser sensors are used to check the length of profile with the proposed length from the software. This is to avoid incorrect lengths and profiles being cut. The sensors will be put at specific lengths along the infeed which will be input in the software files. When profile hits the back fence all covered sensors will trigger, hence, the profile must be larger than the final triggered sensor.

## Step 1 - Adjust the "Light Dark"

Adjust the "Light Dark" balance on the sensor. To do this, using a small flat head screwdriver, turn the light dark dial **clockwise** until the orange light goes off. Then slowly turn **anti-clockwise** until the orange light turns on again, when this happens re-turn a **little clockwise** to turn off the orange light.



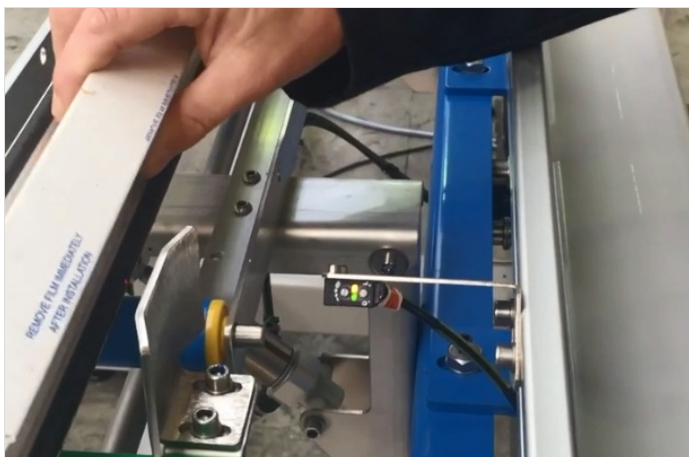
## Step 2 - Adjust Sensitivity

Now adjust the sensitivity. Place an object **80mm** away from the sensor. Now adjust the sensitivity until the orange light turns on.



## Step 3 - Sensor Height Warning

Make sure the height of the sensor is **ABOVE** the gaskets on profile.



## Step 4 - Input Laser Measurements

From the 0 Position, measure the distance of each sensor. These should be written down on the sensors.

In the measurements settings (winMulti> Settings > measurements) update each **offcutSensorX** parameter with the exact measurements recorded.

