Commissioning - Z-Block Calibration

Commonly used during sawing on Z transoms, the Z block operation is used to fasten the profile, making sure it does not move during sawing.

Difficulty	Medium		Duration	30 minute(s)

Contents

Introduction

Commonly used during sawing on Z transoms, the Z block operation is used to fasten the profile, making sure it does not move during sawing. There are 6 possible states the z block can be in. Each of these can have a different length of protrusion for different profiles.
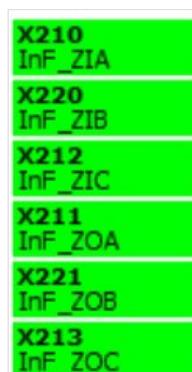
12 x M8 Screws
12 x M8 Nuts
12 x wire numbers 1 - 6

Step 1 - Turret A - Find Position 1 on the Turret

On the **Service > IO** tab use output **Y214** to turn the infeed turret.

Step 2 - Check the Binary Count of the Turret

Each turn of the turrets will change the binary state of the inputs **X210, X220** and **X212**.
Use the table in the picture to ensure the count goes 1-2-3-4-5-6 and back to 1

Value	Binary	Turret I	Turret O
1	001	210	211
		220	221
		212	213
2	010	210	211
		220	221
		212	213
3	011	210	211
		220	221
		212	213
4	100	210	211
		220	221
		212	213
5	101	210	211
		220	221
		212	213
6	110	210	211
		220	221
		212	213

Step 3 - Repeat for the outfeed turret

Use Y215 to pulse the outfeed turret
Each turn of the turrets will change the binary state of the inputs **X211, X221** and **X213**
Use the table in the picture to ensure the count goes 1-2-3-4-5-6 and back to 1

Value	Binary	Turret I	Turret O
1	001	210	211
		220	221
		212	213
2	010	210	211
		220	221
		212	213
3	011	210	211
		220	221
		212	213
4	100	210	211
		220	221
		212	213
5	101	210	211
		220	221
		212	213
6	110	210	211
		220	221
		212	213

Step 4 - Check the Labelling is correct

The turrets should be labelled 1-6 with pneumatic pipe markers
The turret position should be written on the top of each turret in permanent marker

> ⚠ ...Take care to ensure the number match to the actual positions fed back from the binary inputs

Step 5 - Check Turret Home for Infeed and Outfeed turret

X214 InF_ZIHome should signal high (red) when the infeed turret is home
X215 InF_ZOHome should signal high (red) when the outfeed turret is home