

Elongating Toothed Gripper Hole Size

How to elongate the toothed gripper hole slot sizes

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Problem

Some Z sections can tip when loading into the saw infeed (when the channel bar is activated). This leads to misgrips and failure of the toothed gripper to locate in profile because it is slightly tipped towards the backfence

Solution

The gripHoleSlotMode and gripHoleSlotSize parameters have been added to elongate the holes into slots. This was added in v6.4.93.0 of the front end

 ...This is not intended to be a blanket solution to be switched on for every profile. It should only be used for those profiles where there is a problem to be resolved, because it will slow the cycle time of the machine

Parameter	Description	Notes	Range
gripHoleSlotMode	Toothed gripper hole slotting mode	Allows elongation of the toothed gripper holes on all profiles, or specific profiles This helps the gripper pins locate if a profile has rotated slightly in the clamps Slotting modes 0 - off 1 - On profiles where the flip parameter = 'D' 2 - On all Profiles SEE NOTE ABOVE	0 to 2
gripHoleSlotSize	Toothed gripper hole slot size	Movement of Y axis to produce gripper slot in mm Can be + or - A negative value will elongate the hole towards the front of the machine - this is the most common as the profiles tend to roll back A positive value will elongate holes towards rear If elongation in both directions is needed, alter the yGripHolePosition parameter first and elongate +/- from that position  ...If the yGripHolePosition is changed, the gripHoleSlotMode will need to set to 2 because ALL profiles will be affected	-5 to 5