Mul File Specification - Clamppos

Specification of the Clamppos.mul file

Contents

Specification

Sample

Comments

Specification

The Clamppos file contains detains of clamps that have multiple settings or positions depedent on profile parameters. An example is the 2 stage clamps on an autoflow - the side clamps open to a secondary position if the profile is wider than a certain amount and the top clamps open higher if the profile is taller

> 🖐 ...This system was only used on Autoflows A2002-A2004

No	Name	Format	Example	Notes
1	Clamp Pos Reference	Numeric	1	The number is hard coded and used by bthe back end PLC program, so should not be changed
2	Output Reference code	String	OuB_ClampISPos	Look up in IO References. See Stuga Machine IO Dictionary - Outputs
3	Gripper Max	Numeric	9999	Range of X axis gripper positions that this feature works across
4	Gripper Min	Numeric	-800	
5	Trigger Width	Numeric	999	If profile width is bigger than this value, trigger the positioner (logical OR with Height)
6	Trigger Heights	Numeric	40	If profile height is bigger than this value, trigger the positioner (logical OR with Width)
7	On Initialise state	Numeric	1	Output state when machine is initialised
8	Home input	String	InB_ClampISPos	Look up in IO References. See Stuga Machine IO Dictionary - Inputs

Sample

```
1,OuB_ClampISPos,9999.0,9999.0,105.0,999.0,1,InB_ClampISPos
2,OuB_ClampOTPos,0.0,-9999.0,999.0,61.0,1,InB_ClampOTPos
3,OuB_ClampOSPos,9999.0,9999.0,105.0,999.0,1,-1
4,OuF_ClampITPos,-800.0,-9999.0,999.0,40.0,1,InF_ClampITPos
5,OuF_ClampOTPos,9999.0,9999.0,999.0,71.0,1,-1
```