

# Short Pieces At End Of Bar on Microline and ZX5

How to overcome the issue of short pieces at the end of the bar on Microlines and ZX5

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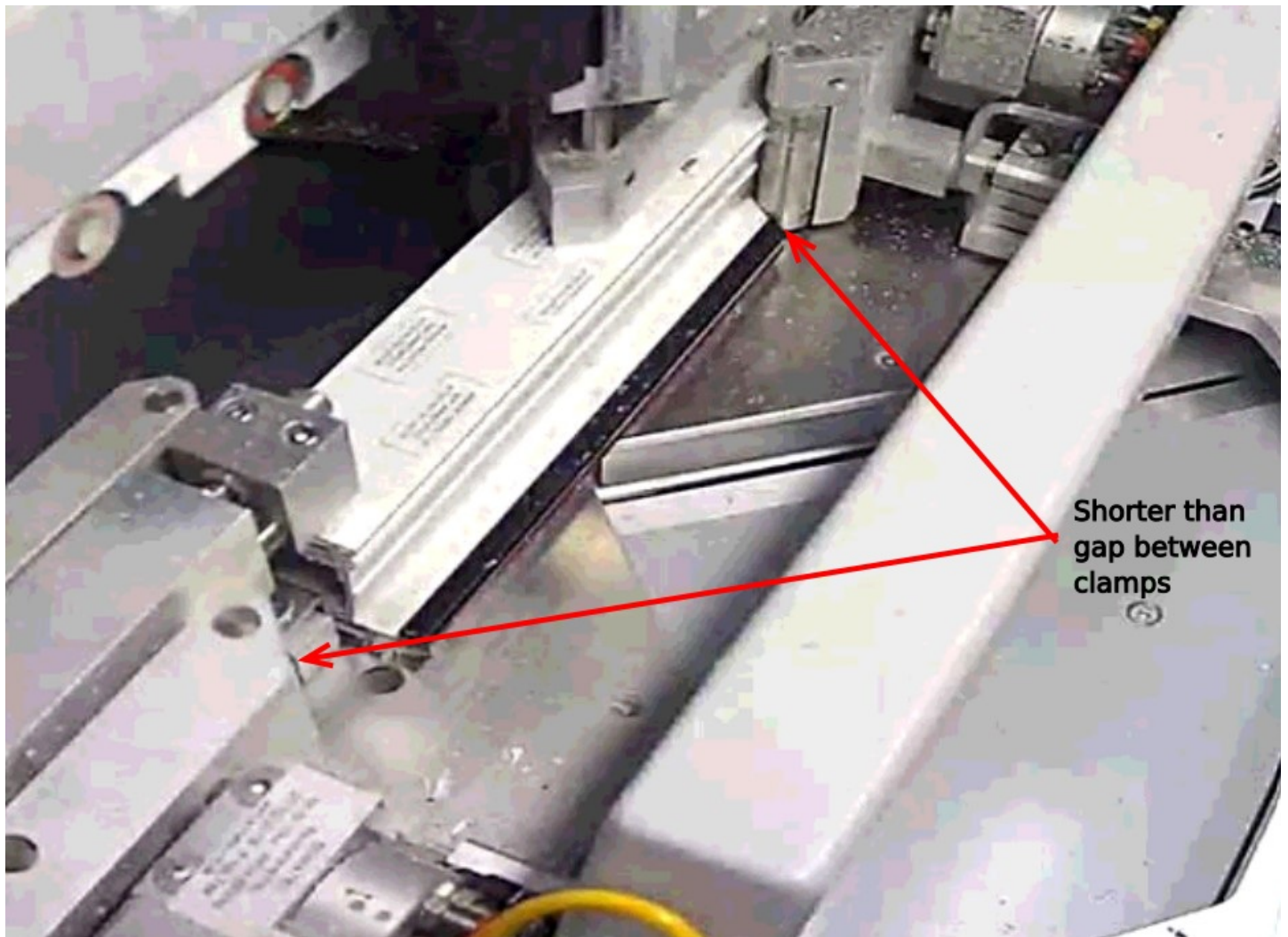
Solution

Comments

## Problem

Due to the gap between the infeed and outfeed clamps in the saw area on ZX5s and Microlines, there is an issue with clamping if a short piece is at the end of the bar.

If the piece is shorter than the distance between the clamps, the clamps don't reach, and the piece falls between the clamps. This only happens if the piece is the last cut on the bar



## Solution

An algorithm exists in the software to force a 'maxable' cut at the end to dissuade the optimiser from putting a short piece at the end of a bar. This might cause a bit of frustration when trying to cut multiple short bits for testing though, as there will always be a maxable cut. This is easy to override though by making the parameter shorter than the length you are trying to cut - it can go down to 200  
Added for ZX5s in software version 6.4.73.0

Parameter is m!ShortPieceLength, default is 400.