

Stuertz Infeed - Changes made to Version 1-GB Table

Changes made on Version 1 GB machine to interface with Autoflow Mk4

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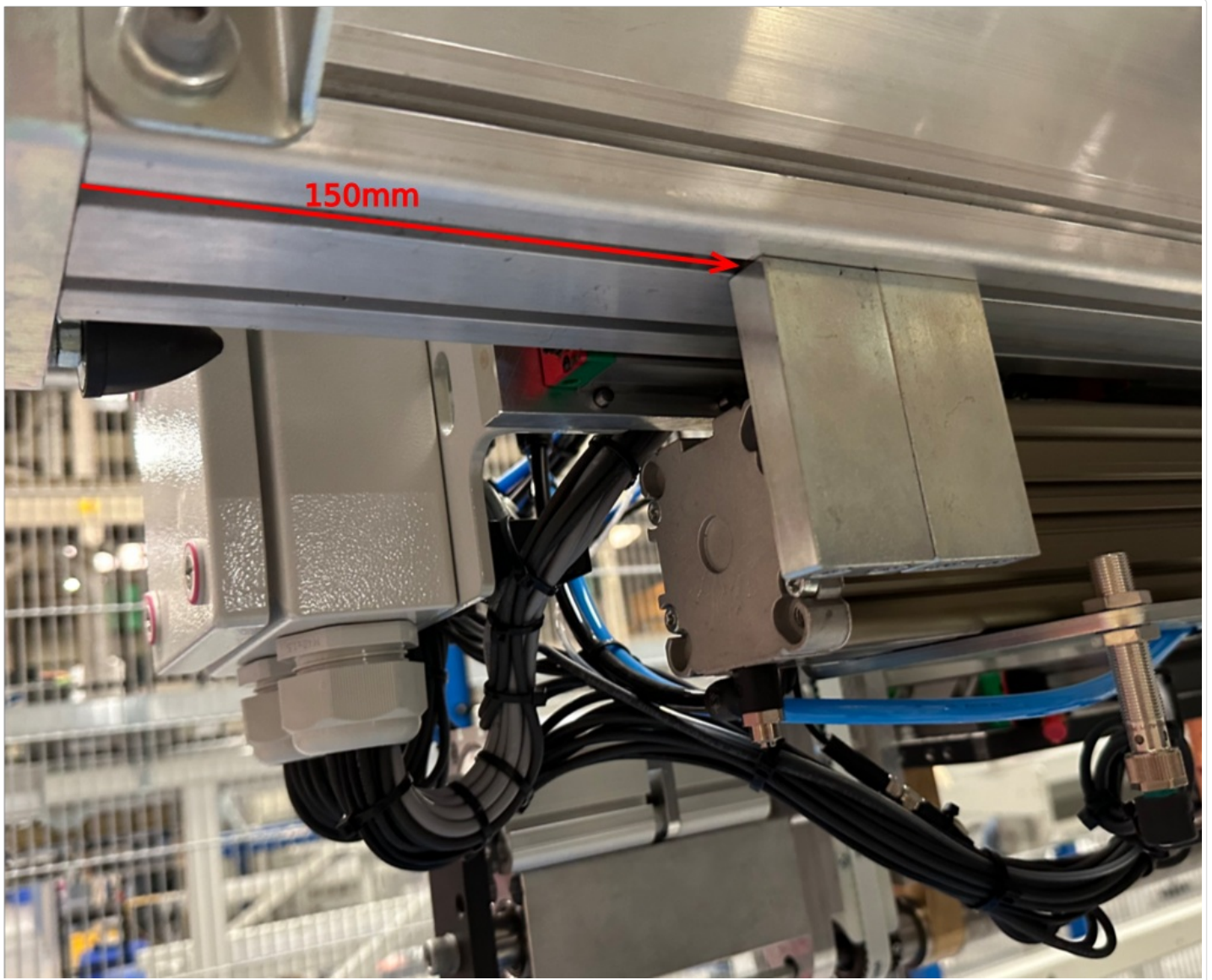
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End Stop Near Machining Centre

End point of buffer around 63mm



Datum Flag

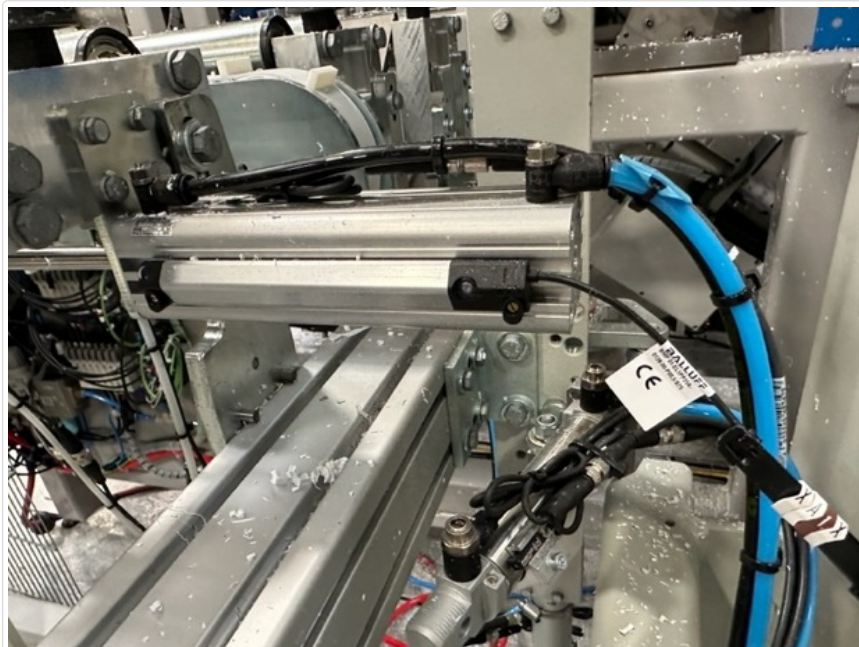


Use the datum flag on infeed end - set to 150mm from end of slot

Material Sensor Separation

See detail on Stuetz Conveyor Motor and Indexing Setup

Width Measurement Sensor



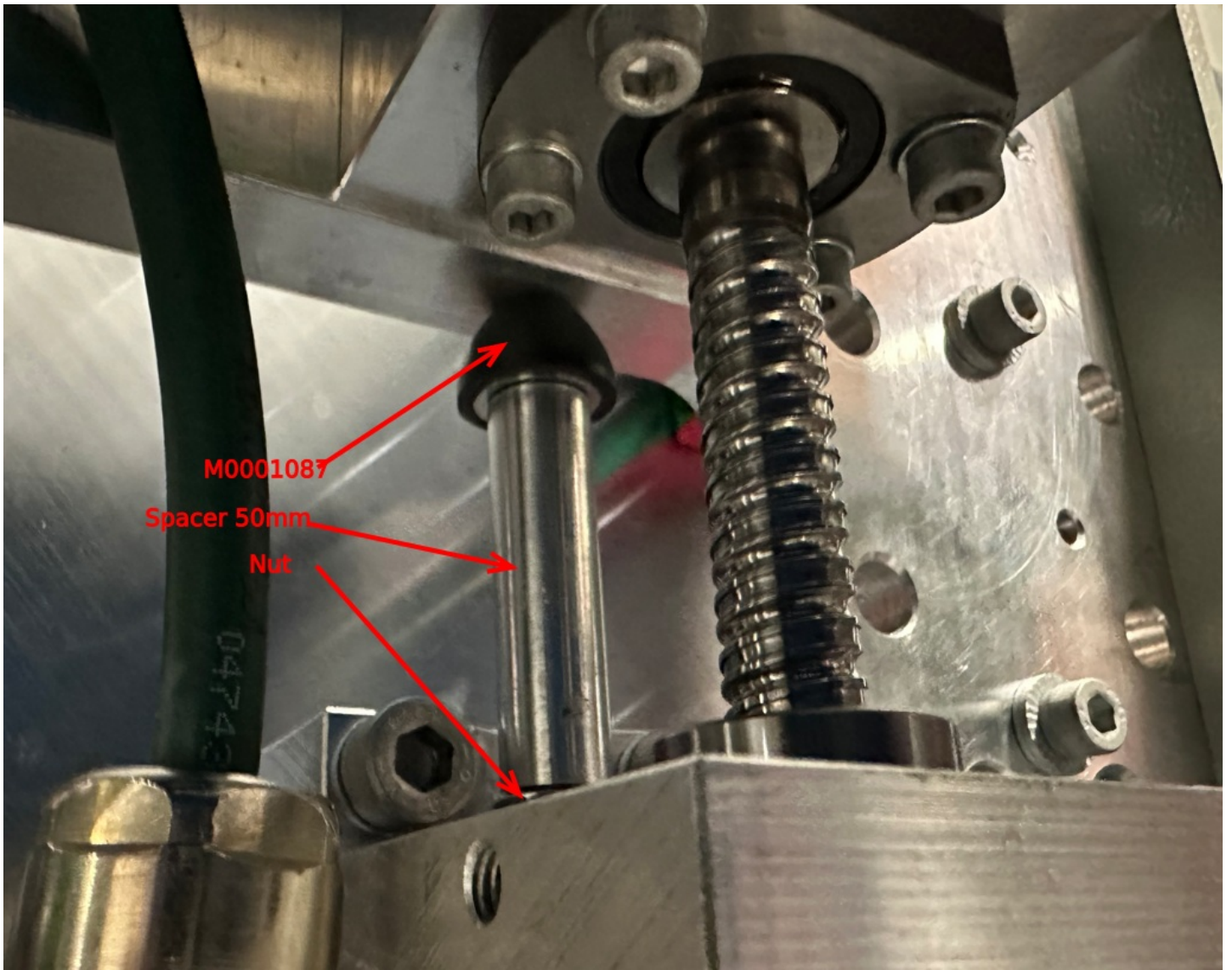
Analogue sensor Fitting on Infeed clamp nearest MH



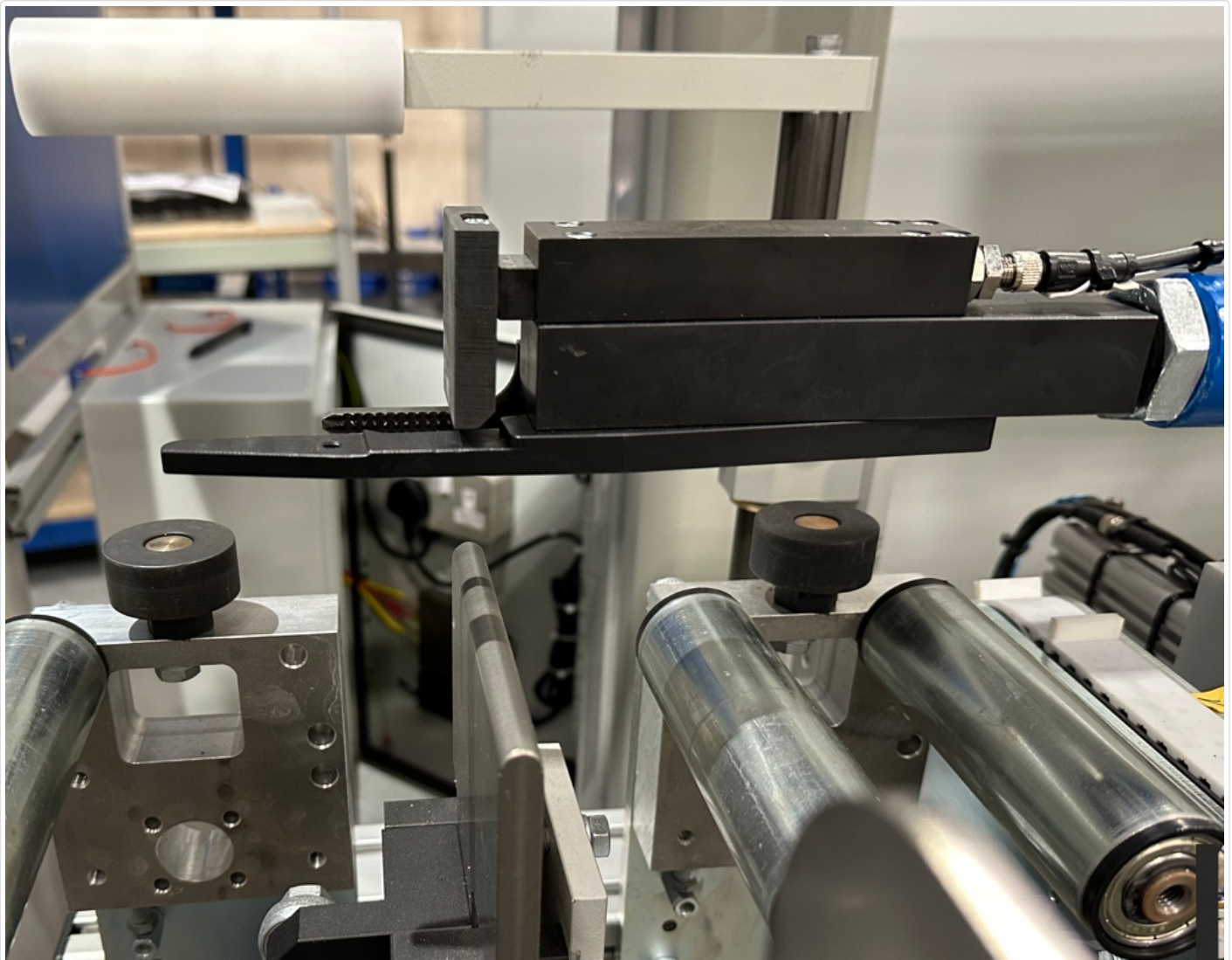
Analogue Fieldbus box next to infeed electrical panel

Gripper Long and Short Cylinders

Z Axis Rubber End Stop (Bottom)



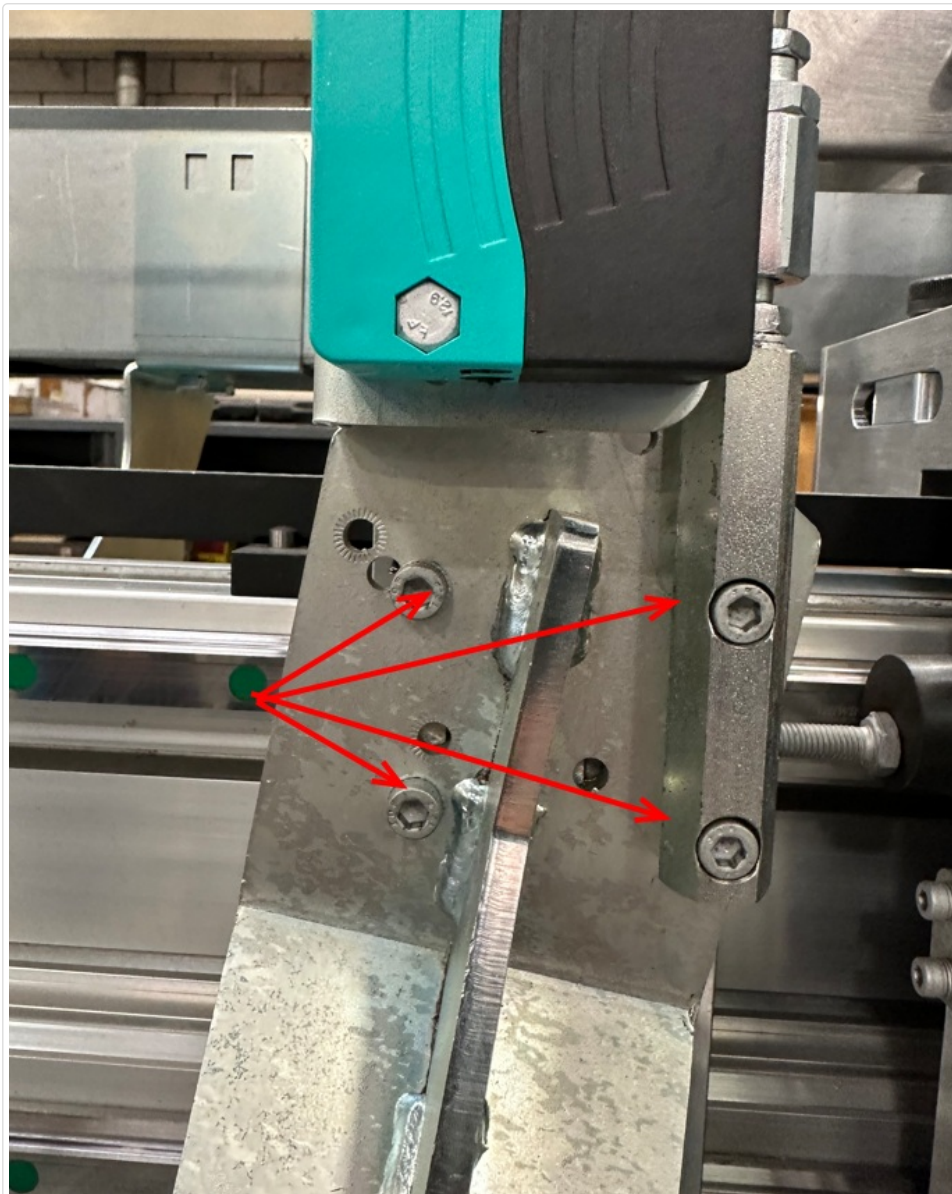
Gripper Handing



Serrated tooth gripper insert at rear

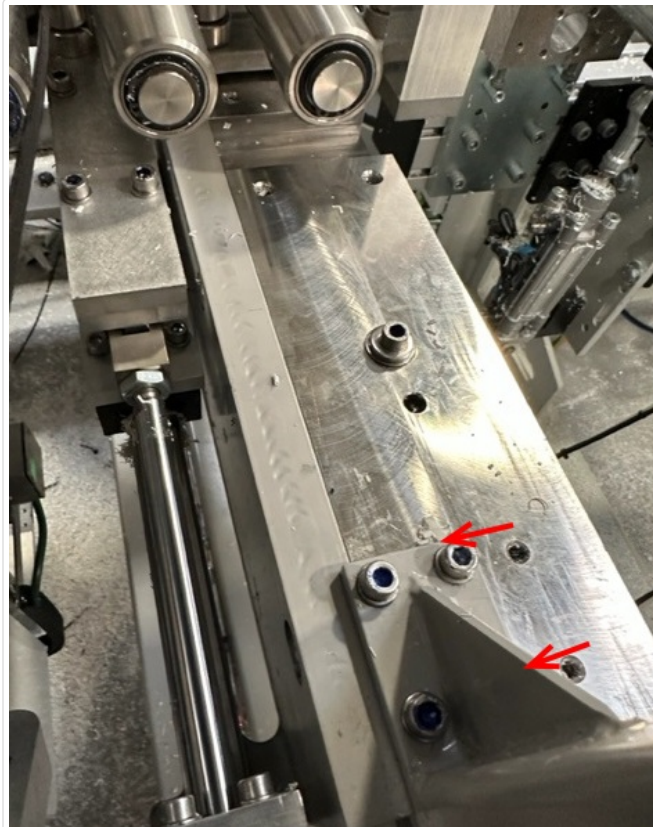
Forward Clamp Opening Height (Vorlaufwagen)

Rotated roller arm on mount to move further away from infeed cylinders



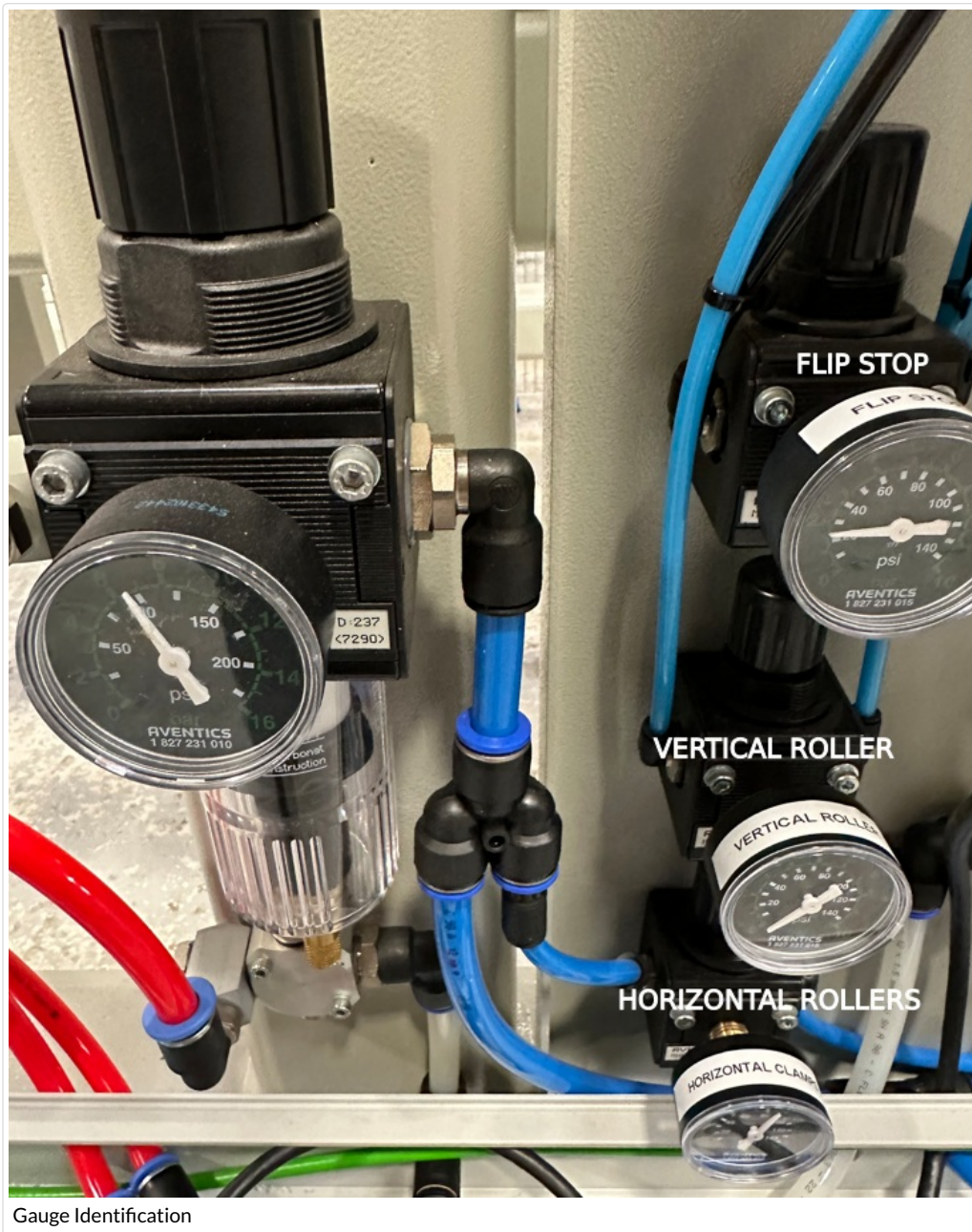
Rotated mount bracket

Also required infeed top clamp to move over one hole



Top clamp moved

Labelling Pressure Regulators



Gauge Identification

Adjusting Flow Control Speeds and Pressures

IO screen system updated to allow for cyclical control of Solenoid / Solenoid operated valves
 See Cyclical Control of Outputs to Aid Cylinder Speed Setup

Cylinder	Function	Goal	Link
Z01A-Z07A	Horizontal Clamps	Prevent tipping of profile	
Z08A	Lifting Roller bed	Smooth Lifting	
Z10A	Profile Stop	Set pressure to flap out of the way easily. Speed to work smoothly	
Z11A-Z12A	Rotating Vertical Clamp	Hold profile square when horizontal clamping to prevent tipping	
Z01G	Forward Clamp (Vorlaufwagen)		

Adjust Conveyor Index Position

See Stuertz Conveyor Motor and Indexing Setup

Check GY to Backfence Parallelism

See Stuertz Infeed - Check GY Position Parallelism

Measuring Sensor Setup

See Stuertz Infeed - Setting Measuring Sensor

Table Parameters

See Stuertz Infeed Table Measurements

Tuning GY and GZ Motors

See GY GZ axis setup with Jetter Motors
Profile Deflection Plate