Stuertz Infeed Table Measurements

Critical measurements and settings for an Autoflow infeed table

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Method

Comments

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> ⚠️ ...Make sure the GX axis is scaled correctly before starting any measurements

> ⚠️ ...Ensure the infeed is set at the correct distance from the machining centre (500mm between feet centreline

- Use the gripper arm as the measuring stick. The datum must be set so that zero is the spindle centreline.
- The measure point is when the gripper nose switch is depressed

Measurement	Description	A2027 Value	Photo
Machining Centre to Infeed spacing	Distance between centrelines of feet	500	
Zero Datum	Centreline of spindles	0	
measureStartPosX	Measuring start position Should be so that measure sensor is on machining centre side of the profile load fence	-880	
infeedToZeroX	Distance from zero to profile load fence (profile side)	615	
measureSensorPos1 measureSensorPos2	Distance of gripper nose (depressed) to offcut measure sensors Sensor 1 nearest MH	1460 1480	
GX Axis Max position	Maximum travel on GX Axis After datum, press estop and manually move to end of travel Note the value and subtract 10mm	7255	
GX Move After Datum	Ideally set to max profile length+infeedZeroToX+100 > ⚠️ ...Must not exceed GX Max pos	6500+600+100 =7200	
stopCylinderToZeroX	Distance from the spindle centreline to the stop cylinder > ⚠️ ...This should always be less than infeedToZeroX	585	
loadOffsetX	Relative distance to move after measuring finished to allow gripper to clear end of bar. This can be measured - end of gripper "swan neck" to measuring sensor	1580	

GX Minimum Position	Absolute minimum position of GX Goal is for gripper nose switch to at least reach saw blade ⚠️ ...Take care with clashing of the Gripper Froward clamp with the MH infeed clamp Ensure the end rubber buffers are set to prevent a mechanical clash between the	-1040	
Infeed Horizontal side clamp positions	These are set up in the clamp setup as the "GripPos" for OuA_P2BFOnx ℹ️ ...Note - bar end should be set to -9999, as this effectively disables the other end of the bar from influencing the clamp on/off cycle	1-950 2-1480 3-2600 4-3700 5-4800 6-6300 7-7050	
GY Min Position	Limited by the backfence clamping in the saw area	10	
GY Max Position		54	
GZ Min Position	Gripper must not bottom out on the saw tables	6	
GZ Max position	ℹ️ ...GY and GZ min / max positions and gripper tooth height (PullGripperHeight) should also be set in the file c:\ddrive\draw.mul	70	